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Notified in A.O.I.s. for the week ending 8th February, 1939.



Small Arms Training
Volume I, Pamphlet No. 7

·303-inch Machine Gun
Part I.—Mechanical Subjects
1939

(RE-PRINTED WITH AMENDMENTS, 1942)

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W. J. KAY

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By Command of the Army Council.

H. J. Creedy

THE WAR OFFICE,
8th February, 1939.

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DISTRIBUTION

This part is issued on a pool basis, the distribution within the unit being left to the discretion of the commanding officer.

Territorial Army units will receive the same distribution as regular units.

Infantry M.G. battalions	85 copies
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W. J. KAY

GENERAL

A. GENERAL PRINCIPLES

1. Small Arms Training, Vol. I, Pamphlet, No. 7 is arranged in three parts: —

Part I.—Mechanical subjects.

Part II.—Training.

Part III.—Fire control.

2. This pamphlet, Part I, deals with the technical training of machine gun platoons and sections.

3. The principles governing the tactical use of the .303-inch Vickers machine gun are dealt with in Field Service Regulations, Vol. II, Cavalry Training, and Infantry Training.

4. Instructions regarding the responsibility for the training of machine gun battalions is contained in Training Regulations.

5. The characteristics and elementary principles of handling machine guns are dealt with in Infantry Training, 1937, Sec. 4.

B. ORGANIZATION

1. Within the machine gun battalion are four M.G. companies, each of three platoons.

2. The platoon is commanded by a subaltern or warrant officer, Class III, and consists of two sections, each of two guns.

In platoon headquarters, in addition to the commander, are:—

Platoon serjeant.

Platoon orderly (motor cyclist).

Two scouts.

Batman.

3. The section consists of headquarters and two sub-sections, each of five gun numbers, one of whom acts as driver to the truck.

In section headquarters are:—

Section commander.

Section corporal.

Range-taker.

Orderly.

4. The complete personnel, stores, equipment and ammunition of M.G. companies are carried in vehicles.

i. Company headquarters in trucks and lorries.

ii. Platoons in 6 trucks, sub-divided as under:—

Platoon headquarters .. 2 trucks.

Each section .. 2 trucks.

The distribution of personnel and stores of the M.G. platoon is set out in Sec. 15.

C. SYSTEM OF TRAINING

1. General.—i. Before personnel can be considered individually fit to take their places in a M.G. platoon, they must first receive instruction in preliminary training.

It is essential that this training be continuous; where part only can be carried out at the depot, the remainder must be completed immediately after joining the battalion. This will probably necessitate centralization under battalion arrangements, the men not being posted to platoons until their preliminary training has been completed.

ii. On completion of the preliminary training period such personnel should receive further practice as opportunity offers, as individuals in handling the gun, and complete their knowledge of mechanical detail. They will also begin training as members of sub-sections in section and platoon collective training exercises.

iii. Officers, N.C.Os. and potential N.C.Os. must receive instruction in fire control and leadership.

iv. Personnel of both section and platoon headquarters must receive instruction in their duties in the field.

This training of headquarters' personnel is an essential preliminary to the handling of sections and platoons in the field.

2. Preliminary training.—i. The table shown on p. 7 gives the subjects which must be taught in preliminary training. As a guide for organizing that training the course is shown divided into four stages, with a suggested number of hours for each lesson or group of lessons. The sequence of lessons in each stage should be arranged to suit local conditions.

The division into stages is not arbitrary nor does it attempt to give a dividing line between depot and battalion periods.

ii. The practices of Part I, A, A.M.G.C., may be fired in any order and at such times as instructors consider that individuals have reached a sufficiently high standard of training.

They should not, however, be fired in one day.

PRELIMINARY TRAINING.

Serial No.	Subject	Stages of training				Hours
		1	2	3	4	
1	General description and 30-yds. range demonstration.	Lesson 1.		Lessons 2, 3, 4.	Lessons 5, 6.	4
2	Mechanism.	Lessons 7, 8, 9.	Lessons 10, 11, 12.	Lesson 16.	Lessons 17, 18.	4
3	General maintenance of gun and tripod.	Lessons 13, 14.	Lesson 15.	Lesson 34-38.		
4	Stripping.	Lesson 19.	Lesson 20.			
5	Spare parts.	Lessons 21, 22.	Lessons 23, 24.			
6	Immediate action.	Lessons 29-33.				
7	Instrument and aiming.	Lessons 45-51.				
8	Elementary gun drill.		Lessons 52-56.			
9	T.O.E.D.		Sec. 12.			
10	Part I, A, A.M.G.C.		Range course.			
11	Advanced M.G. handling.		Lessons 57-60.			
12	Vehicles.		Lesson 61.			
13	Visual training.		Lesson 63.			
14	Section drill.			Lesson 64.		
15	Platoon drill.			Lessons 65-72.		
16	Section drill night firing.					
17	Observation of fire and ranging.					
	Total hours.	60		67	35	26

NOTE.—Sec. 13 (Signals) will be introduced as required during the training.

3. Subsequent training of private soldiers.—i. On completion of preliminary training private soldiers will be posted to platoons.

With the object of producing a higher standard of training, further practice in all subjects taught in preliminary training must be carried out, and, in addition, instruction must be given in mechanical subjects, such as special stoppages and causes of stoppages (Lessons 25 and 26), repairs (Lesson 27), and blank firing attachment (Lesson 28).

ii. They should be exercised in the field in section and platoon training exercises covering all tactical operations.

iii. Part I, B, A.M.G.C., should be fired during the weapon training year in which the men join their battalions, and after the completion of preliminary training. They may also be required, if they have reached a sufficiently high standard of training, to fire Parts III and IV of the A.M.G.C.

iv. Part II, A.M.G.C., will be fired by the men in their second weapon training year if they have qualified in Part I, B (see Pamphlet No. 15).

v. Range-takers, orderlies and scouts, in addition to being trained as gun numbers, will require instruction in their special duties.

Range-takers will be trained in accordance with the instructions laid down in Pamphlet 10, and orderlies and scouts as specified in Infantry Training and Infantry Section Leading. Orderlies will also be trained to carry out certain technical duties in the field (see Sec. 22).

vi. All ranks, in addition to their training as machine-gunners, should receive instruction in driving mechanical vehicles.

The importance of training in tactical driving cannot be over-estimated.

vii. Judging distance tests will be carried out in accordance with Sec. 16.

4. Officers and N.C.Os.—i. A suggested course in fire control and leadership designed for junior officers and N.C.Os., with an allotment of hours to cover approximately three weeks, is set out below. The organization of this course should be centralized under battalion arrangements.

ii. In addition, officers and senior N.C.Os. should receive further instruction in:—

Director, No. 4, Mark II ..	Lesson 39.
Field plotter	Lesson 41.
Testing director for angle of sight	Lesson 43.
Spotlight apparatus ..	Appendix I, Part II.
Night firing	Lessons 117, 118, 119 and 121.
Map shooting	Lesson 122.
T.O.G.	Lesson 123.
Fire direction and control charts	Lesson 124.
Safety calculated from the map	Lesson 132.

FIRE UNIT COMMANDER'S COURSE

Serial No.	Subject.	Lessons	Hours
1	General principles	Lessons 95-98	5
2	Direct fire.	Lessons 99-105	9
3	Indirect fire	Lessons 106-116	18
4	Night firing.	Lessons 117, 118, 119 (Lecture).	1
		Lesson 120.	3
5	Fire direction and control charts.	Lesson 124 (Lecture).	1
6	Flanking and overhead fire.	Lessons 125-131, 133	13
7	Tactical lectures.	Pl. in attack	1½
		Pl. in Defence	1
		Pl. in withdrawal	1
8	Field duties.	Introductory (Sec. 22)	1
		Lessons 90-94.	9½
		H.Q. training (Sec. 21), lecture.	1
		Fd. duties exercises.	6
9	Miscellaneous.		
	i. Drills.	Method of conducting (Secs. 17, 18, 19)	1
	ii. Advanced M.G. handling.	Method of instructing, (Sec. 14).	2
	iii. Observation of fire and ranging.	Sec. 20	2
	iv. Instruments.	Lessons 40, 42, 44	2
Total			78

5. Headquarters training.—The action and duties of the personnel of platoon and section headquarters in coming into and out of action are laid down in Sec. 22. The procedure must be applied to each case according to the tactical situation, the role given to the platoon and the ground.

Before starting collective training, platoon and section headquarters should be thoroughly grounded in this procedure by means of exercises without the gun numbers, both on the sand table and on the ground. This training can be carried out at a time when the remaining personnel of the company are otherwise employed.

The method of instruction is contained in Secs. 21 and 22.

D. SAFETY PRECAUTIONS

On all occasions when the gun and dummy cartridges are used for instructional purposes, the instructor will carry out the following safety precautions:—

- i. Inspect all locks to ensure that the striker does not protrude through the firing pin hole.
- ii. Inspect all ammunition to ensure that all cartridges are dummies.

Note.—When instruction is being given in mechanical subjects D.P. stores, if available, will always be used.

SECTION 1.—THE GUN AND TRIPOD

LESSON 1.—GENERAL DESCRIPTION AND DEMONSTRATION OF CHARACTERISTICS

Instructor's Notes

Stores.—

Gun, tripod, belt box, belt and dummy cartridges, spare parts case, condenser can and tube, gun chest, spare barrel, cleaning rod.

(Diagram if available.)

Do not expect the man to remember the names of all the parts.

Only mention the names of the main parts of the gun and tripod, and point out these as they are named.

Strip the gun down and show the parts affected by recoil.

Emphasize the strength of all parts.

Use diagrams (if available) when explaining the water cooling system.

Demonstration of characteristics should follow immediately the general description.

A. General Description (Plate 1)

1. Name of gun.—The .303-inch Vickers Machine Gun.
2. Weight of gun.—About 40 lb. (with water in the barrel casing).
3. Rate of fire.—About 500 rounds a minute.
4. Forces which work the gun.—The gun is worked by two forces:—
 - i. The explosion of the charge, which drives the recoiling portions back, and
 - ii. The fuze spring, which forces the recoiling portions forward again; the action of the gun is therefore automatic.
5. Parts affected by recoil.—The parts of the gun affected by recoil are:—
 - Muzzle cup.
 - Barrel.
 - Right and left side plates.
 - Crank and crank handle.
 - Fuzee.
 - Fuze spring.
 - Connecting rod.
 - Lock.
 - Feed block.

6. **Barrel casing.**—On the outside of the barrel casing are fitted the muzzle attachment, the foresight, two screwed plugs for filling and emptying the water, adapter for condenser, and cork plug.

Inside the barrel casing are the barrel and steam tube. The barrel is surrounded by water for cooling purposes. When the gun is fired, the barrel becomes hot, which in turn heats the water. After about 500 rounds rapid the water boils and gives off steam.

Inside and at the top of the barrel casing is the steam tube, which is fitted with a sliding valve. On the steam tube are three holes, one at the rear and two at the front.

When the gun is fired with elevation, the valve covers the rear hole and allows the steam to enter the front hole and pass out through the steam escape tube.

When the gun is fired with depression, the valve covers the front hole, thereby allowing the steam to enter the rear hole and again pass out through the steam escape tube.

Fitted to the adapter is the condenser tube which carries the steam from the steam escape tube into the condenser can. In order to condense the steam, the condenser can must be about two thirds full of water and the end of the condenser tube placed below the level of the water.

7. **Breech casing.**—The breech casing consists of two outside plates, bottom plate, front and rear covers, and rear cross-piece. On the left side of the breech casing are the fuze spring and box, a bracket with fittings for the dial sight, and left slide; on the right side the check lever and right slide. On the rear cover is the tangent sight; on the bottom plate the sliding shutter, and on the rear cross-piece are the traversing handles, safety catch and thumb-piece. The rear cross-piece is held in position by the T fixing pin.

8. **Feed.**—The gun is fed by a belt containing 250 rounds, which passes through the feedblock from right to left.

9. **Tripod.**—The tripod consists of three legs with jamming handles, cross-head, socket, traversing clamp, direction dial and elevating gear. Attached to the crosshead are the cross-head and elevating joint pins by means of which the gun is fixed to its tripod.

Elevation or depression is obtained by the elevating gear, direction by the traversing clamp.

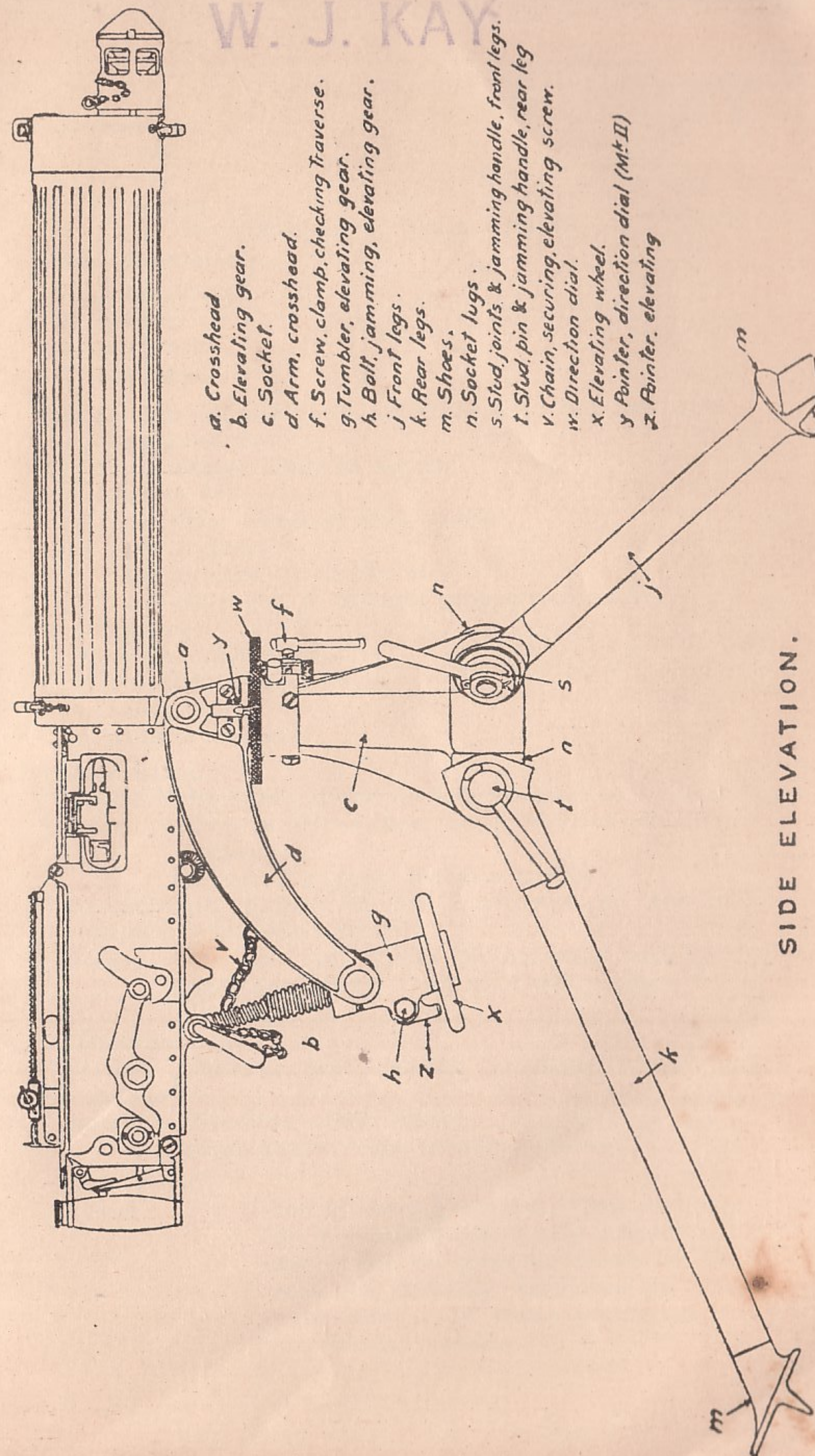
The weight of the tripod is about 50 lb.

10. **Gun chest.**—For the purpose of transit the gun is placed in the wooden chest provided, which also carries the cleaning rod and spare barrel.

PLATE I

MOUNTING, TRIPOD, 303-IN., M.G., MARK IV

[To face p. 12.]



11. Demonstrate.—

- i. To load.
- ii. To fire.
- iii. To unload.

B. Demonstration of Characteristics.

1. Main characteristics.

- (1) Concentrated
- (2) Volume
- (3) Accurate
- (4) Sustained

Fire.

- (5) Ranges beyond those effective for rifles and light machine guns.
- (6) Small target while in action.
- (7) Able to fire:—
 - (a) Over heads of own troops.
 - (b) Indirect.
 - (c) Blinded by smoke, etc.
 - (d) By night, if daylight preparation made.

Due to:—

Fixed mounting.
 Strong mechanism.
 Belt feed.
 Water cooling.

Demonstration.

- i. Effect of mounting tripod on soft ground.

Lesson.—Stamp in tripod legs, when tactical situation allows.

Occasionally relay between bursts.

- ii. Concentrated nature of fire unaffected by human element (fired with punch).

Lesson.—Provided that sights set correctly and gun laid accurately, tired man will produce fire effect.

- iii. Defective tripod.

(Loose jamming bolt causing elevating wheel to rotate.)

Lesson.—Elevating wheel sticky.

Occasionally relay between bursts.

2. Rates of fire.

Normal

1 belt in about 2 minutes. This rate can be maintained indefinitely without undue strain on guns or personnel. It may be suitably employed in the neutralization of areas within which the enemy is suspected.

Rapid ... 1 belt in about 1 minute. The availability of ammunition and the strain on guns and personnel will limit the length of time during which this rate of fire can be maintained. It will be employed in engaging vulnerable or fleeting targets and may form part of neutralization and harassing fire tasks.

Note.—For harassing fire tasks the requirements of machine guns is intermittent fire over a period of time, opened at irregular intervals at normal and rapid rates, with a view to maximum effect from a relatively small expenditure of ammunition.

Demonstration.

- i. Rates of fire.—Rapid— $\frac{1}{2}$ belt.
Normal— $\frac{1}{2}$ belt.
- ii. Flexibility (three widely dispersed plates on butts).
M.G. (firing direct) very flexible.
N.B.—No. 2 helps No. 1 by loosening clamp.
- iii. Swinging traverse.
Favourable targets under about 400 yards' range.
N.B.—Clamp fairly sticky.

3. Disadvantages.

Mechanical breakdown	..	Care and training.
Steam	Condenser.
Smoke	Other smoke in war.
Noise	Deceptive.
Muzzle blast	Wet sandbags, groundsheet.
Flash	Screen from flanks.

Demonstration.

Muzzle blast.—Gun mounted over dusty patch.

Lesson—avoid dust;

put down wet sandbags, etc.

Note.—On conclusion of this demonstration each man under instruction should fire a burst of 10 rounds.

SECTION 2.—MECHANISM.

Instructor's Notes

Stores for Lessons 2-6.—

Gun, tripod, spare parts case, belt box, belt and dummy cartridges, empty cartridge case, and spare feedblock, skeleton lock, diagrams.

The preparation paragraph affects the instructor only.

Imitation will not be carried out by the private soldier.

When explaining any mechanical movement, show it by means of demonstration, combined with explanation.

Use diagrams to assist.

LESSON 2.—BACKWARD MOVEMENT.

Instructor's Notes

Preparation.—

- i. Place an empty case between the upper and lower projections of the gib.
- ii. Half load.
- iii. Press the thumb-piece.
- iv. Remove the fuze box and spring.
- v. Raise the rear cover.
- vi. Remove the outer casing, muzzle attachment.
- vii. Prepare a spare feedblock by placing a dummy cartridge in front of the bottom pawls.

Demonstration.—

- i. Push back the recoiling portions from the front.

The class to watch the following:—

- (a) Recoiling portions moving to the rear.
- (b) Feedblock slide moving to the right.

- ii. With spare feedblock—action of feedblock.

Explanation.—

On the gun being fired, the recoiling portions are forced to the rear owing to recoil, assisted by gases which strike the front cone and rebound on to the muzzle cup. This backward movement causes the feedblock slide to move to the right, thereby allowing the top pawls to engage behind a round which is in position in front of the bottom pawls.

LESSON 3.—ROTATION OF THE CRANK

*Instructor's Notes**Preparation.—*

- i. Place an empty case between the upper and lower projections of the gib.
- ii. Half load.
- iii. Press the thumb-piece.
- iv. Remove the fuze box and spring.
- v. Raise the rear cover.
- vi. Remove the outer casing, muzzle attachment.
- vii. Prepare a spare feedblock by placing a dummy cartridge in front of the bottom pawls, and the slide over to the right.

Demonstration.—

1. Push back the recoiling portions from the front until the crank handle is vertical. Complete the movement by pressure on the knob of the crank handle.

The class to watch the following:—

- i. Tail of crank handle rolling.
- ii. Further rotation of crank handle sending recoiling portions forward and feedblock slide over to the left.

2. With spare feedblock—action of feedblock.

Explanation.—

1. When the recoiling portions come to the rear, the tail of the crank handle strikes the roller, thus causing the crank to rotate, which withdraws the lock.

This rotation winds the fuze chain round the fuze, thus extending the fuze spring.

2. The continued rotation of the crank handle on the roller, assisted by the fuze spring, forces the barrel and side plates forward.

This forward movement forces the feedblock slide over to the left, the top pawls placing a round in position ready to be gripped by the extractor, the next round being drawn in front of the bottom pawls.

LESSON 4.—BACKWARD MOVEMENT OF THE LOCK

*Instructor's Notes**Preparation.—*

- i. Place an empty case between the upper and lower projections of the gib.
- ii. Half load.
- iii. Press the thumb-piece.
- iv. Remove the fuze box and spring.
- v. Raise the rear cover.

Demonstration.—

1. Draw back the recoiling portions from the rear.

The class to watch the following:—

- i. Live round and empty case being withdrawn.
 - ii. Live round being brought in line with chamber.
 - iii. Rotation of the tumbler.
2. (With skeleton lock.)

The class to watch:—

- i. Rotation of tumbler.
- ii. Withdrawal of firing pin.
- iii. Compression of lock spring.
- iv. Action of sear.

Explanation.—

As the lock comes to the rear, it brings with it a live round from the feedblock, and an empty case from the chamber. When the horns of the extractor reach the rear of the cams, the extractor is forced down by the ramps on the rear cover, thus bringing the live round in line with the chamber; the empty case probably falls off. During this movement the side lever head is raised and bears on the tail of the tumbler. This rotation of the tumbler withdraws the firing pin which compresses the lock spring. The firing pin is held back by the sear.

LESSON 5.—FORWARD MOVEMENT OF THE LOCK

*Instructor's Notes**Preparation.*

- i. Half load.
- ii. Remove the fuze box and spring.
- iii. Pull the crank handle on to the roller and pull the belt.
- iv. Raise the rear cover.

Demonstration.

Force the crank handle on to the check lever.

The class to watch the following:—

- Fuze chain unwinding.*
Lock going forward.

Explanation.—

The fuze spring rotates the crank and forces the lock forward. The extractor places the live round in the chamber and, being forced to rise by the action of the side and extractor levers, thus grips the round in position in the feedblock. The firing pin hole is now opposite the round in the chamber. If the empty case has not fallen off, it will be forced off when the extractor rises.

LESSON 6.—FIRING ACTION

*Instructor's Notes**Preparation.*

- i. *Half load.*
- ii. *Remove the trigger bar.*
- iii. *Pull the crank handle on to the roller and pull the belt.*
- iv. *Raise the rear cover.*

Demonstration.

- i. (a) *Allow the lock to go forward showing the side lever head depressing the sear.*
- (b) *Place the trigger bar over trigger and trigger bar lever.*
- (c) *Press the thumb-piece and show trigger bar pulling back the tail of the trigger.*
- (d) *Show pressure being released from the thumb-piece and the action of the trigger bar.*
- ii. *With skeleton lock—repeat i (a), i (c) and i (d) above.*

Explanation.—

1. Each time the lock goes forward the side lever head depresses the sear, thus allowing the firing pin to move forward until checked by the nose of the trigger engaging in the bent of the tumbler. If the safety catch is raised and the thumb-piece pressed, the trigger bar is withdrawn, which in turn disengages the nose of the trigger from the bent of the tumbler. The firing pin is now driven forward by the lock spring.

2. When pressure on the thumb-piece is maintained, continuous fire will result, as the trigger will be kept out of action.

When this pressure is released, the nose of the trigger re-engages in the bent of the tumbler and prevents the firing pin from going forward.

SECTION 3.—GENERAL MAINTENANCE OF GUN AND TRIPOD

1. Care and cleaning of the gun is of the utmost importance in order that the gun may fulfil any task demanded of it.

2. Machine guns and equipment should be examined when first taken over. Further frequent examinations will also be necessary.

*Instructor's Note**Stores for Lessons 7-12.—*

Gun, tripod, belt boxes, belt with dummy cartridges, spare parts, box and case, condenser can and tube, cleaning rod, flannelette and old linen.

LESSON 7.—CLEANING

1. *Daily cleaning.*—The outside of the gun will be cleaned daily, and all parts of the mechanism which can be reached without stripping will be wiped over with an oily rag. The inside of the barrel will be left oily. On completion of daily cleaning the gun will be inspected both for cleanliness and damage. In examining the barrel the mirror reflector will be used.

To clean the barrel.—Take out the lock, take off the muzzle attachment and muzzle cup. Place a piece of dry flannelette (4 by 2) in the eye of the cleaning rod and insert it into the muzzle end of the barrel. Ensure that the bush is over the muzzle, and move the rod backwards and forwards. Repeat with fresh pieces of flannelette until the barrel is clean.

To oil the barrel.—Repeat the above with a smaller piece of flannelette well soaked in oil.

To use the double pull-through.—Before use it is essential to see that the weight is not bent and that the cord is in good condition. Ensure that the gauze is thoroughly oiled and that the muzzle protector is placed on the barrel. The barrel may either be left in the gun or taken out for the purpose of cleaning. If left in the gun, proceed as follows:—

Take out the lock. Take out the elevating joint pin and depress the gun. Pass the pull-through from the breech end through the barrel. Lower the rear cross-piece. Replace the elevation joint pin. Pass the loop end on the pull-through under the crank and replace the lock in the "Clear Gun"

position. The pull-through is then pulled backwards and forwards through the barrel. Care must be taken to keep the cord taut and prevent wear on the breech end of the barrel.

If the barrel is removed from the gun for cleaning, it should be fixed in a suitable vice or held firmly by a man.

An effective means of cleaning the barrel is with boiling water. Having removed the barrel from the gun, adopt the same procedure as used in cleaning the rifle (see Pamphlet No. 3, page 15).

2. **Weekly cleaning.**—The gun will be stripped down and all parts cleaned and left dry for inspection. Where the bore has become rusty, it should be wiped out with flannelette; boiling water should then be used, and, finally, the barrel cleaned with the double pull-through.

After inspection the gun will be oiled before being put away.

Spare parts and stores will also be examined and checked.

LESSON 8.—EXAMINATION, TESTS AND ADJUSTMENTS

1. Muzzle attachment. Free from fouling and burrs, disc cleaned, split pin and chain in good condition.

2. Muzzle cup. Clean, threads neither damaged nor badly worn.

3. Steam tube. Keeper screw in correct position, sliding valve working. (To test this, take the gun off the tripod and give it a rocking movement. The movement of the valve should then be heard.)

4. Foresight. Blade in good condition.

5. Front cover catch. Working correctly.

6. Fuzee spring and fuzee. Claws of spring, fuzee and chain in good condition. Vice pin not bent.

Instructions for weighing and adjusting the fuzee spring:—

Take out the lock and place the loop of the spring balance over the knob of the crank handle. Pull the balance vertically upwards, resting the wrist on the breech casing. The reading indicated when the crank handle begins to move will be the weight of the fuzee spring. This weight should be between 7 and 9 lb. If the spring is over, or not up to, weight, adjust by means of the vice pin. Generally six clicks (three revolutions) make a difference of about 1 lb. Turning the vice pin upwards decreases the weight and vice versa. The tension of the fuzee spring should always be kept as high as possible, consistent with maintaining the normal rate of fire of about 500 rounds a minute.

7. Tangent sight. Apertures in good condition. Top and bottom screws secure. Slide moving freely.

8. Rear cover lock. Automatic fastening of rear cover when down. Cover lock screwed axis pin screwed fully home.

9. Safety catch. Automatic action of spring.

10. Firing lever.—

i. Thumb-piece cannot be pressed in unless safety catch is raised.

ii. When safety catch is raised and thumb-piece pressed, lock is fired.

11. Trigger bar and spring. No burrs or roughness on trigger bar. Spring forces trigger bar forward quickly.

12. Recoiling portions. Remove the fuzee spring and work the recoiling portions backwards and forwards. They should move freely.

Instructions for weighing the recoiling portions:—

Remove the fuzee spring. Place the crank handle nearly vertical. Place the loop of the spring balance over the right end of the crankshaft and pull slowly to the rear. Immediately the recoiling portions begin to move read the weight shown on the spring balance. The weight should not exceed 4 lb.

If the weight exceeds 4 lb., this is probably due to tight packing. This can be reduced by well oiling the packing in the cannellure and gland, and moving the recoiling portions sharply backwards and forwards. Re-weigh and repeat the above as necessary. If, however, it is found that the necessary reduction in weight cannot be achieved by this means, examine the gun for damaged breech casing or side plates.

13. Connecting rod. Adjusting nut tight.

14. Lock. Instructions for testing the lock.

i. *Side and extractor levers.*—Remove the feedblock and keep the front cover raised. Draw back the crank handle and let it go slowly forward on to the check lever. If correct, the extractor should now be in its highest position.

ii. *Bents of sear and firing pin.*—Remove the feedblock and keep the front cover raised. Pull the crank handle on to the roller, press the thumb-piece and, while maintaining pressure, let the crank handle go slowly forward on the check lever. The extractor should be kept up to its highest point before the sear releases the firing pin.

- iii. *Extractor*.—Remove the lock, examine the face for burs and flaws.
- iv. *Nose of trigger and bent of tumbler*.—Cock the lock, release the sear; the firing pin should now be held back.
- v. *Firing pin*.—See that the point is not broken. A broken firing pin can be recognized without stripping the lock by releasing the lock spring with the extractor up. If correct, the firing pin will then protrude from the firing pin hole, and can be withdrawn by raising the tail of the tumbler. If it does not protrude, or if protruding but the point is not withdrawn when the tail of the tumbler is raised, some part of the firing pin is broken.

Instructions for testing the weight of the lock spring.—

Fully cock the lock. Place the bottom of the lock on a flat surface. Place the loop of the spring balance over the side lever head and left hand on the top of the lock. Draw the side lever head upwards with the spring balance; immediately the tumbler begins to rotate the balance should record from 12 to 14 lb.

LESSON 9.—EXAMINATION, TESTS AND ADJUSTMENTS.—*continued*

1. *Barrel*. The barrel should be carefully examined for rust, cuts, erosion, cord-wear, bulges and metallic fouling.

Proceed as follows:—

Remove the barrel from the gun. First with the eye close to the breech, then with the eye some inches back from the breech, examine the bore, rotating the barrel slowly. Carefully examine the lead to see if undue erosion has taken place.

The barrel should now be reversed and examined carefully from the muzzle end in a similar manner.

Inaccuracy in shooting may be due to the presence of metallic fouling.

Instructions for the renewal of packing.—

- i. To renew packing at the breech end of the barrel.—

Should the gun leak at the breech, empty the barrel casing. Draw out the recoiling portions. Wind a strand of asbestos in the cannellure of the barrel, pressing it together with a thin piece of wood or the point of a screwdriver or knife, until the cannellure is full. Then smooth the asbestos down flush with the barrel, oil it and re-assemble the parts.

- ii. To renew packing at the muzzle end of the barrel.—

Should the gun leak at the muzzle, stand the gun on the rear cross-piece, remove the muzzle attachment and unscrew the gland. Re-pack, or, if necessary, replace the asbestos, having first oiled it, by winding it loosely round the barrel, and, while winding, push it in with a No. 3 punch, piece of wood or any blunt-ended instrument that will fit; screw on the gland as tightly as can be done by hand, return the gun to a horizontal position, hang the lock and work the recoiling portions backwards to ensure that they move freely. If the packing is found to press too hard on the barrel, the gland should be removed and one or two strands of asbestos taken out.

Finally see that the gland is screwed firmly home by means of the combination tool.

To test packing.—

Fill the barrel casing with sufficient water to cover the barrel and work the recoiling portions backwards and forwards. There should be no leakage.

Test the recoiling portions for correct weight.

2. *Feedblock*. Slide working freely; pawls and springs in good condition.

3. *Sliding shutter*. Catch and spring working automatically.

Sliding shutter working freely. If the movement of the sliding shutter is sticky, examine for:—

- i. Dirt or grit.
- ii. Dented bottom plate due to connecting rod being dropped when no lock is in the gun.

4. *Axis and other pins*. See that all pins are correct.

5. *Tripod*. There are many places where slight play, caused by wear, may occur. Although the play in each particular part may be very slight, the accumulated effect may cause serious unsteadiness in the gun.

Vertical play. Usually found in the elevating gear. This may be taken up by loosening the jamming bolt, screwing in the tumbler nut and re-tightening the jamming bolt.

Lateral play. Usually due to the jaws of the cross-head having become widened.

Further points for examination:—

- i. Clutch plates free from grit.
- ii. Jamming handles not bent.

- iii. Chains correct.
- iv. Feathers on joint pins.

6. Belt and belt boxes.

Belts. Free from dirt; brass strips correct, neither torn nor frayed.

Belt boxes. Clean and undamaged.

LESSON 10.—PREPARATION OF GUN AND TRIPOD FOR FIRING

1. Strip the gun down.
2. Examine and clean all parts.
3. Oil the outside of the barrel.
4. Re-assemble the gun.
5. Dry the inside of the barrel, muzzle cup and muzzle attachment.
6. Muzzle cup to be firmly screwed on.
7. Level the gun, fill the barrel casing with water by removing the screwed plug at the breech end, and the cork plug.
8. Oil.—
 - i. Recoiling portions.
 - ii. Ramps.
 - iii. Trigger bar.
9. Weigh.—
 - i. Fuzee spring.
 - ii. Recoiling portions.
 - iii. Lock spring.
10. Traversing handles and can in spare parts case filled with oil.
11. Check the contents of the spare parts case and box.
12. i. Examine the condenser tube for damage.
ii. Test the fitting of the condenser tube to the gun.
13. Condenser can to be two-thirds full of water.
14. Spare barrel packed, ready for firing, and cleaning rod placed in gun chest.
15. Examine the tripod.
16. Ammunition dry and clean.
17. Belts.—
 - i. in good condition.
 - ii. correctly filled.

18. Examine the belt boxes.

Action in cold weather. Keep the friction of the recoiling portions as low as possible, *i.e.* between two and three lb., and adjust the weight of the fuzee spring to not more than seven lb. at the start. Remove all old oil from the lock and keep the front face and slide of the extractor, also the extractor levers, free from oil. Wrap straw, sacking or blankets round the barrel casing. Work the recoiling portions by hand at frequent intervals.

Action in sandy countries. Ensure that only a small quantity of oil is used.

Working parts wiped over with a slightly oily rag will prevent rust through the night and will be sufficient lubrication for working the gun during firing.

LESSON 11.—POINTS DURING FIRING

1. Watch the water supply. (As soon as the water begins to boil, and so long as it continues to boil, about $1\frac{1}{2}$ pints will be lost for every two belts fired.)
2. Ensure that the belt.—
 - i. Is kept in line with the feedblock.
 - ii. Has free movement.
3. See that all repairs are carried out immediately.
Lock repairs.—To replace any part of the lock, the ordinary sequence for stripping the lock must be followed, until the required part is reached.
In the case of a lock spring, where the broken portions fall clear, a new lock spring may be assembled without stripping the lock.
4. During a temporary cessation of fire.—
 - i. Oil up:—bearing parts of barrel;
recoiling portions (except muzzle cup);
ramps;
trigger bar.
 - ii. Ensure that the front cone, muzzle cup and jamming handles are tight, and that the end of the condenser tube is in the condenser can below water level.
5. Anti-gas measures.
See Pamphlet No. 3, Lesson 4.

LESSON 12.—POINTS AFTER FIRING

1. On the range.—
 - i. Unload, remove the lock, muzzle attachment and muzzle cup.

- ii. Clean the barrel of superficial fouling with the cleaning rod and oiled flannelette, followed by dry flannelette.
- iii. Use the double pull-through to remove any metallic fouling which is still left in the barrel.
- iv. Re-oil the barrel with the cleaning rod.
- v. Oil the muzzle cup, muzzle attachment and lock.
- vi. Re-assemble the gun.
- vii. Sort live rounds from empty cases.

Note.—It may assist in the cleaning of the barrel on return to barracks if the water is left in the barrel casing.

2. On return to barracks.—

- i. Strip the gun and thoroughly clean all parts.
- ii. Release tension from the fuzee spring.
- iii. Pour boiling water through the barrel and then, if necessary, use the double pull-through.
- iv. In order to prevent the formation of rust on the exterior of the barrel due to condensation of moisture, completely empty the barrel casing, and remove the screwed and cork plugs to permit the free circulation of air through the casing. If the gun is likely to be so left for any length of time, remove the asbestos packing from the cannellure and gland.

- v. Clean and overhaul the tripod, belts and belt boxes, spare parts and ammunition.

(a) Belts:—Dry wet belts.

If dirty or greasy, clean by soaking for two hours in a solution consisting of—

One part soda.

Three parts soft soap.

Ten parts water.

After soaking scrub, and when dry, plug the belts with the belt plug. Care must be taken in using the belt plug, or loose pockets will result.

(b) Belt boxes.—Remove all dirt and mud, and wipe over the outside with an oily rag.

SECTION 4.—STRIPPING

Instructor's Notes

Stores.—

Gun, tripod, spare parts, case and box.

- i. *Lay emphasis on the "Points to be observed" section.*
- ii. *The squad should be proficient in Lessons 13, 14, 15, 16 and 17 before going on to Lesson 18.*

LESSON 13.—GENERAL POINTS

1. Use the correct tool, *e.g.* screwdrivers according to the size of the screw, correct punches, etc. If this rule is not observed, screws get burred and can only be removed by an artificer.

2. Before attempting to withdraw screwed axis pins, make certain that the threads of the screw are fully unscrewed.

3. When replacing screwed axis pins, do not use force; the threads will engage without unnecessary pressure.

If this rule is not observed, the threads (which are extremely fine) will become so burred that it will be impossible to replace the pin, *e.g.* cover lock, screwed axis pin.

4. When raising the rear cover, do not throw it upwards, but lift it. The hinges are liable to strain. Before lowering see that the lock is correctly in the gun.

5. Before closing down the front cover, see that the feed-block is correctly in position and the front cover catch raised.

6. The firing pin should never be released unless the extractor is up against the top stop.

7. When removing parts secured by chains, do not tug on the chain; otherwise they get broken and the part eventually is lost, *e.g.* outer casing split pin, cork plug, screwed plugs, tripod pins.

8. With reasonable care defects and breakages in machine guns should be of extremely rare occurrence. They are simply due to neglect of ordinary precautions.

9. Direct hammer blows must never fall on any part of the gun. Wood must always be placed over the part to receive blows from a hammer or mallet.

10. In stripping examinations no time limit will be imposed, in order to avoid damage to the gun by careless handling.

LESSON 14.—STRIPPING THE GUN

1. Lock. Unload, pull the crank handle on to the roller, raise the rear cover, see that the extractor drops, place the finger between the extractor and stop and lift the lock—at the same time allowing the crank handle to move slowly forward until the lock is released from the side plate. Give the lock a slight turn and lift it out.

2. Muzzle attachment. Withdraw the split pin, turn the outer casing and remove it. Unscrew and remove the muzzle cup.

3. Feedblock. Raise the front cover and lift out.

4. Fuzee spring box. With the right hand at the rear and the left at the front, press the box forward until clear of the stud and remove. Disconnect the fuzee chain and remove the box and the spring.

5. Fuzee. Turn the fuzee to the rear until the lugs on the stem are free to be withdrawn.

6. Recoiling portions. Raise the rear cover, unscrew the T fixing pin and lower the rear cross-piece; remove the right and left slides and draw out the barrel and side plates. Disconnect the side plates, removing the left one first.

To assemble the gun.—

1. Reverse all the foregoing operations.

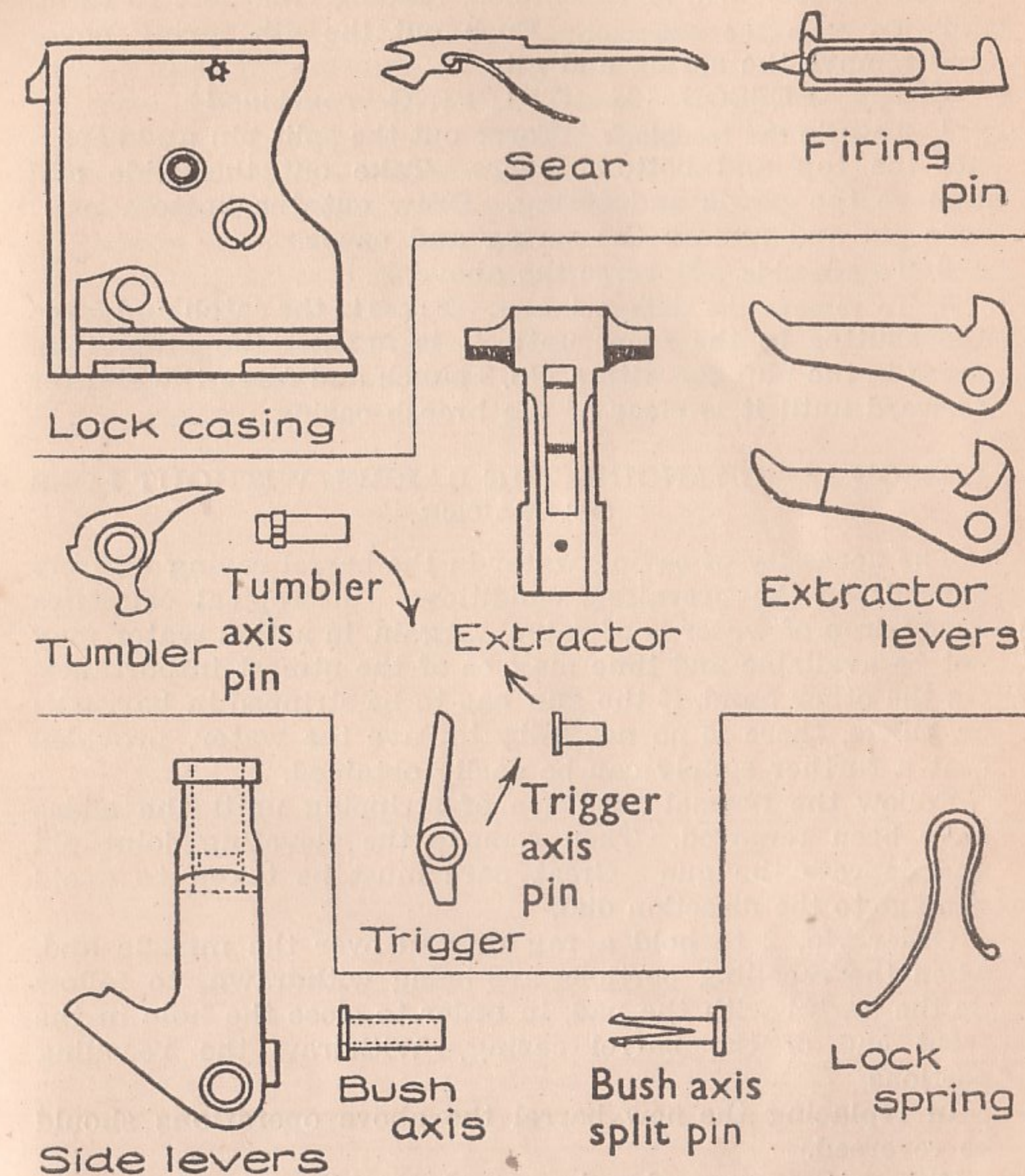
2. When assembling the barrel and side plates, ensure that the radial groove is uppermost and that no force is used. If the side plates are not home on the barrel trunnions and crankshaft, the barrel must be withdrawn and the side plates properly assembled; otherwise burrs on the crankshaft may occur.

LESSON 15.—STRIPPING THE LOCK (PLATE 2)

1. To strip the lock.—See that the lock is cocked; force out the side lever split pin and axis bush; remove the side levers, extractor levers and extractor. Push out the tumbler axis pin and remove. Release the lock spring, push out the trigger axis pin. Remove the trigger, lock spring, firing pin, and sear with spring.

2. To assemble the lock.—Reverse the above except:—

- i. Replace the tumbler before the trigger.
- ii. The lock spring must be forced home, the long arm towards the extractor, when the lock is in the fired position, and when all other parts are assembled.



Component parts of extractor



Note.—The names and parts of the lock are in the order in which the lock will be assembled, reading from left to right.

3. To strip the extractor.—Push out the gib spring cover and remove the spring and gib.

LESSON 16.—STRIPPING—*continued*

1. To strip the feedblock.—Force out the split pin and separate the top and bottom levers. Take out the slide and remove the pawls and spring. Draw out the bottom pawl axis pin and remove the spring and pawls.

2. To assemble.—Reverse the above.

3. To remove the sliding shutter.—Press in the catch and force the shutter to the front until it is against the stop, then press in the plunger with a No. 3 punch and force the shutter forward until it is clear of the breech casing.

LESSON 17.—CHANGING THE BARREL WITHOUT LOSS OF WATER.

The necessity of saving water in the barrel casing entirely depends on the prevailing conditions. In tropical countries every drop of water is of value. Again, in action water may not be available and time may be of the utmost importance. On the other hand, if the gun has to be stripped in barracks or billets, there is no necessity to save the water, provided that a further supply can be easily obtained.

Follow the normal sequence of stripping until the slides have been removed. Then remove the elevating joint pin and depress the gun. Great care must be taken to avoid damage to the direction dial.

Order No. 2 to hold a rag or pad over the muzzle and, when the recoiling portions are being withdrawn, to follow up the barrel with the pad, in order to close the hole in the front end of the barrel casing. Withdraw the recoiling portions.

In replacing the new barrel the above operations should be reversed.

The water may also be saved by allowing it to run from the barrel casing into a receptacle, when the barrel will be changed by the normal procedure.

LESSON 18.—STRIPPING COMPONENT PARTS.

1. Front cone, muzzle attachment. Using the combination tool, unscrew the front cone from the outer casing muzzle attachment.

2. Gland of the muzzle attachment. Using the combination tool, unscrew the packing gland from the barrel casing.

When assembling, ensure that the gland is screwed fully home.

3. Front cover catch. To remove the spring and plunger, force the plug inwards and give $\frac{1}{4}$ turn by means of a screw-driver, when the plug will be forced out by the spring.

Before the plunger is removed, it must be turned so that the slides are free to pass the lugs in the catch.

4. Tangent sight. Unscrew the axis pin and remove. Remove the tangent sight piston and spring.

5. Rear cover lock. Unscrew the axis pin and remove. Remove the rear cover lock and spring.

6. Trigger bar. Remove the rear cover lock and trigger bar spring and withdraw the trigger bar.

7. Roller. Remove the split fixing pin, collar and roller.

SECTION 5.—SPARE PARTS

The importance of knowing what is and what is not carried spare should be impressed on all machine gunners. It is essential to know where to find any spare parts that may be required. All spare parts must be given their proper names. A list of deficiencies should be kept inside each box, and the necessity of checking spare parts whenever opportunity occurs must be emphasised. Breakages and losses must be reported immediately. Spare parts must be kept slightly oiled.

Instructor's Notes

Stores:—

Gun, tripod, spare parts, case and box.

The sequence of instruction will be:—

Having laid out the whole of the contents of the spare parts box, case and wallet, teach the squad as follows:—

Hold up each article (in accordance with the official list of spare parts) and call out the correct name given to it. The use of the spare part being dealt with will be explained.

LESSON 19.—DESCRIPTION

Describe the spare parts box, case and wallet, teach the names and use of spare parts.

LESSON 20.—PACKING

Teach the method of packing.

Contents of Wallet

Cork for plug	1
Cup, muzzle attachment	1
Disc, muzzle attachment	1
Fuzee, with chain	1
Gib	1
Pins, trigger lock	1
„ tumbler	1
„ firing	1
„ keep split, $\frac{1}{8} \times 2\frac{1}{2}$ in. (for Mk. IV tripod mtg.) ..	3
Pliers, side cutting, pairs	1

Contents of Wallet—continued

Protector, muzzle	1
Pull-through, double	1
Punches, No. 3	1
„ No. 5	1
Reflector, mirror	1
Screwdrivers, small	1
Sear, with spring	1
Spring, gib	1
„ lock	2
Trigger	1
Tumbler	1
Washers, adjusting, No. 1 .003 in.	3
„ „ No. 2 .005 in.	3
Wire gauze (pieces)	1

Contents of Spare Parts Case

Balance, spring	1
Can, oil	1
Flannelette for binding lutin pads, yards (a) ..	8
Lock breech	1
Lutin, oz. (a)	6
Plug, clearing	1
Spring, fuzee	1
Tool, combination	1
Wallet	1

Contents of Spare Parts Box

Blocks, feed	2
Boxes, small parts	3
Bushes, axis, side levers	1
Collars, roller	1
Cork for plug	1
Cups, muzzle attachment	1
Discs, muzzle attachment	4
Eyelets, long, oz.	$\frac{1}{2}$
Fuzee, with chain	1
Gib	1
Gland, packing	1
Hammer	1
Lever, extractor, left	1
„ „ right	1
Packing, asbestos (5-yard pieces)	4

(a) Being replaced by Patch, first aid (see Sec. 7; sub-para. 4).

Contents of Spare Parts Box—*continued*

Pins, trigger lock	1
„ tumbler	1
„ firing	2
„ fixing crank handle	1
„ split, collar, roller	2
„ „ keeper, $\frac{1}{8} \times 2\frac{1}{2}$ in. (for Mk. IV tripod mtg)	6
„ „ bush, axis, side lever	1
„ „ check nut, long	3
„ „ muzzle attachment	1
„ T fixing rear cross-piece	2
Plugs, belt	1
„ cork, complete	1
„ screwed	1
„ front cover catch	2
Plungers, front cover catch	2
Roller	1
Screws, clamp, checking traverse	1
Screwdrivers, large	1
Sights, night, back and fore, each	1
„ fore	1
„ tangent	1
Spanner, adjustable	1
Springs, bottom pawl	1
„ rear cover lock	2
„ front cover catch	2
„ gib	1
„ lock	4
„ safety catch with piston	2
„ sear	2
„ shutter catch	2
„ tangent sight	1
„ top pawls feed block	2
„ trigger bar	2
Strips, long	25
„ short	25
Tool, repairing belts	1
Wire gauze (pieces)	4
Washers, elevating nut (tripod Mk. IV)	6

SECTION 6.—STOPPAGES AND IMMEDIATE ACTION

1. In order that the men may attain a high standard of training in dealing with stoppages, it is essential that the instructor should prepare the stoppages accurately in order that the correct immediate action may be applied by the No. 1.

Setting up stoppages should not be taught to the private soldier.

2. The following tables give the preparation, immediate action, etc., and will be taught to the various categories of machine gunners as under:—

- | | |
|----------------------------------|--|
| i. Columns 1, 3 and 4 .. | All machine gunners. |
| ii. Column 5 | When the machine gunner is proficient in immediate action. |
| iii. Columns 1, 2, 3, 4 and 5 .. | All instructors. |

Instructor's Notes

Stores for Lessons 21-26.

Gun and tripod.

Condenser can and tube.

Belt box, belt and dummy cartridges.

Bulged dummy.

Two dummy cartridges with prepared thick rims.

Front portion of a separated case and telescoped separation.

Spare parts case.

Covering for crank handle.

An aiming mark.

1. The squad will be seated on the right side of the gun, so that the crank handle is visible and the actions of the instructor more clearly seen.

2. A target must always be indicated at the beginning of the lesson.

3. While the stoppage is being set up, Nos. 1 and 2 will be at the "rest" position at the gun with their heads turned aside. The instructor will order "Position" followed by "Fire." He will then remove the covering from the crank handle, when the I.A. will be performed.

4. The stoppage should be set up as described.

5. Immediate action is not complete until the gun has been correctly relaid and fired.

6. The rear cover should never be opened nor closed with the lock home or the tangent sight raised.

7. If the lock cannot be drawn back, open the front cover and force down the extractor.

8. The rear and front covers, when lowered, must always be fastened correctly.

9. A lock must never be changed with cartridges on the face of the extractor.

10. Should it be necessary to release the lock spring with the lock out of the gun, this should be done with the extractor held right up, so that the firing pin hole is opposite the firing pin.

11. When No. 2 takes an active part in I.A., his duties will be taught first.

12. As proficiency is attained, training should be carried out in darkness, or with Nos. 1 and 2 blindfolded.

13. Finally, men should be practised in carrying out I.A. without the assistance of a No. 2.

14. Lessons are divided into:—

21. First position stoppage.

22. Second position stoppage.

23. Third position stoppage.

24. Fourth position stoppage.

25. Special stoppages.

26. Causes of stoppages.

Note.—Proficiency in Lessons 21, 22, 23 and 24 should be attained before Lesson 25 (special stoppages) is taught.

Lesson 26 should not be taught until proficiency is attained in Lessons 21 to 25 inclusive.

1. Stoppages in the automatic action of the gun may be classed under two main headings: —

i. Temporary, which are due to:—

(a) Neglect of points before or during firing.

(b) Faulty ammunition.


(c) Ignorance on the part of the gun team.

(d) Failure of some part of the gun of which a spare is carried.

ii. Prolonged, which are due to failure of some part which cannot, as a rule, be put right by the team under fire, or without skilled assistance. These necessarily put the gun out of action for a more or less prolonged period.

2. On the knowledge and training of the team depends the rapidity with which temporary stoppages can be overcome.

1st POSITION STOPPAGE

Position of crank handle	Method of preparation	Immediate action	Prevention of recurrence	Probable cause
<p>I</p>  <p>Indication— The lock is unable to come back far enough to allow the extractor to drop.</p>	<p>Perform half the loading motions; pull the crank handle slowly back until the horns of the extractor have engaged with the steps of the cams; let go the crank handle and pull the belt to the left.</p> <p>Note.—In all cases except where the stoppage is caused by a weak charge the preparation must be repeated.</p> <p>To set up a stoppage caused by a weak or broken gib spring, perform half the loading motions; open the rear cover, withdraw and lift up the lock. Slide the cartridge on the face of the extractor half way down the lower projection of the gib, replace the lock and pull the belt to the left.</p> <p>For range purposes— increase the weight of the fuze spring.</p>	<p>i. Pull the crank handle on to the roller, pull the belt to the left, and let go the crank handle.</p> <p>ii. If failure recurs, repeat (i) and lighten the fuze spring by three "clicks."</p> <p>iii. If, after carrying out (i), the crank handle stops in the same position when going forward, pull the crank handle on to the roller, open the rear cover, clear the face of the extractor, change the lock and reload.</p>	<p>ii. Attend to points before and during firing.</p>	<p>The extractor has not dropped. This may be due to:—</p> <p>i. Weak charge.</p> <p>ii. (a) To heavy fuze spring. (b) Want of oil in working parts. (c) Grit in working parts.</p> <p>(d) Excessive packing.</p> <p>(e) Worn barrel.</p> <p>(f) Tight pockets.</p> <p>(g) Friction due to frozen oil or water.</p> <p>iii. Weak or broken gib spring.</p>

2nd POSITION STOPPAGE

Before the second position stoppage is taught, the use of the clearing plug will be taught as follows:—
To remove a separated case. Insert the tapered portion of the clearing plug with the centre pin pushed back, into the chamber. Push the pin well home by allowing the lock to go forward. Then, keeping a firm pressure on the crank handle, give the clearing plug handle a rocking motion, pull back the crank handle; knock back the handle of the plug and withdraw the tapered portion of the plug from the chamber. The front portion of the separated case will be found adhering to it. Knock the centre pin back and remove the separated case.

Position of crank handle.

II



Indication—The lock is unable to go fully home after recoil.

Method of preparation	Immediate action	Prevention of recurrence	Probable cause
<p>i. (a) Insert a bulged dummy cartridge as the first cartridge in the belt and load.</p> <p>For range purposes—place a bulged dummy cartridge in the belt.</p> <p>(b) Perform half the loading motions. Open the rear cover, withdraw and lift up the lock. Place the front portion of a separated case securely over the bullet of the cartridge on the extractor. Replace the lock, close the rear cover, pull the belt and let the crank handle go slowly forward.</p> <p>Note.—Another method is to use a dummy with the front portion of a separated case soldered on it.</p>	<p>i. Force the crank handle to the rear and call out "Clearing plug," open the rear cover, lift up the lock, and examine the cartridge on the face of extractor. If a damaged cartridge or an undamaged cartridge with the front portion of a separated case adhering to it is found, call out, "Don't want it," clear the face of the extractor and reload.</p>	<p>i. (b) and (ii). If a series of separated cases occurs, change the lock. If, after changing the lock, they still occur, remove the lock and place a No. 1 and No. 2 washer in front of the adjusting nut. At the first opportunity the washers will be placed behind the adjusting nut. Note.—This will be reported to the armourer.</p>	<p>i. (a) Damaged cartridge. (b) Separated case with front portion withdrawn telescoped on undamaged cartridge.</p>

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<p>ii. Perform half the loading motions, raise the rear cover and lift out the lock. Place the front portion of a separated case lightly over the bullet of the round on the extractor and allow the lock to go slowly forward, ensuring that the separation will remain in the chamber. Close the rear cover and pull the belt to the left.</p>	<p>ii. If an undamaged cartridge, with no front portion of separated case adhering to it is found on the extractor, clear the face of the extractor, replace the lock, keeping the crank handle on the roller. Use the clearing plug and reload.</p>	<p>ii. Separated case, front portion remaining in chamber.</p>
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3rd POSITION STOPPAGE

Before teaching the stage in the third position stoppage when the extractor requires forcing down, explain the correct method of using the clearing plug. Grip the clearing plug with the left hand at the top of the handle, the tapered portion resting on the top of the clenched hand. Place the end of the handle on the top of the extractor, and with the right hand give the clearing plug a sharp blow downwards.

Position of crank handle	Method of preparation	Immediate action	Prevention of recurrence	Probable cause
III.	<p>i. Perform half the loading motions, then pull the crank handle on to the roller, and raise the rear cover; pull the belt just sufficient to move a cartridge halfway into the face of the feed block. Allow the crank handle to go slowly forward so that it will remain in the third position, and lower the rear cover.</p> <p>ii. Proceed to load, but the crank handle must be eased forward the second time in order that it may remain in the third position.</p> <p>Note.—In the case of a stoppage due to friction, the preparation must be repeated.</p>	<p>i. Slightly raise the crank handle, pull the belt to the left, let go the crank handle and then strike it down on the check lever.</p> <p>ii. If the stoppage recurs, repeat the immediate action, unload, oil the working parts and reload.</p>	<p>i. Examine the cartridges in the belt.</p> <p>ii. Attend to points during firing.</p>	<p>i. A cartridge is fed up slightly crosswise.</p> <p>ii. Friction in lock, etc.</p>



Indication.—The extractor is unable to rise to its highest position. If the feed block slide is jammed, there is a fault in feed


<p>iii. Pull out the fourth cartridge in the belt about half an inch. Perform half the loading motions; pull the crank handle slowly back until the horns of the extractor have engaged with the steps on the cams. Draw the recoiling portions to the rear by forcing the knob of the crank handle forward, and the tail to the rear, at the same time pulling the belt to the left. Bring the crank handle on to the roller and ease forward.</p> <p>For range purposes.—Fill a belt badly, or bend a long brass strip, or place the box at an angle to the feed block.</p> <p>iv. Place a dummy with a thick rim as second cartridge in the belt. Proceed to load, easing the crank handle forward the second time.</p> <p>For range purposes.—Damage the rim of a dummy cartridge and place it in the belt.</p>	<p>iii. If (i) fails, examine the feed block slide. If jammed, No. 1 calls out "Feed block," pulls the crank handle on to the roller (in order to do this it may sometimes be necessary for No. 2 to force down the horns of the extractor), raises the rear cover and hangs the lock. No. 1 then draws back the recoiling portions while No. 2 depresses the pawls and withdraws the belt. No. 1 then allows the recoiling portions to go forward, thus allowing the feed block slide to go over to the left. No. 2 then straightens the rounds in the belt. No. 1 will then lower the rear cover, pull the crank handle on to the roller, pull the belt to the left and let go the crank handle.</p>	<p>iii. Attend to points before and during firing.</p> <p>Note.—Badly filled belts are the chief cause of stoppages in the third position.</p>	<p>iii. (a) Bent or damaged long brass strip.</p> <p>(b) Badly filled belt.</p> <p>(c) Worn or loose belt pockets.</p> <p>(d) Belt box not in line with the feed block.</p>
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3rd POSITION STOPPAGE—continued

Position of crank handle	Method of preparation	Immediate action	Prevention of recurrence	Probable cause
	<p>Notes.—1. A special dummy can be used, having a thin washer soldered on to the base.</p> <p>2. This stoppage should seldom be practiced on the range, since the thickened rim may damage the grooves of the extractor.</p>	<p>iv. If the slide is free, No. 1 calls out "Extractor" and opens the front cover. No. 2 forces down the horns of the extractor. No. 1 clears the face of the extractor. No. 2 depresses the pawls, withdraws the belt and removes the first cartridge in the belt, and then No. 1 closes and locks the front cover and reloads.</p>		<p>iv. Thick rimmed cartridge.</p>

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4th POSITION STOPPAGE

Position of crank handle	Method of preparation	Immediate action	Prevention of recurrence	Probable cause
<p>IV</p> <p>Indication—There has been no explosion, or, if any, there has been little or no recoil, the lock remaining in its forward position.</p> 	<p>i. Load. Press the thumb-piece. For range purposes—insert a dummy in the belt.</p> <p>ii. Load and press the thumb-piece, and on No. 1 applying the immediate action the instructor says "Gun will not fire."</p> <p>For range purposes—insert two dummies in the belt.</p> <p>iii. Press the thumb-piece. Insert the belt in the feed-block until the first cartridge is in line with the finger-piece of the bottom pawls.</p> <p>For range purposes—leave a space in the belt.</p>	<p>i. Pull the crank handle on to the roller, pull the belt to the left and let go the crank handle.</p> <p>ii. If (i) fails, pull the crankhandle on to roller twice, change the lock and reload.</p> <p>iii. If, when performing (i), No. 1 notices that more belt than usual comes through to the left, he performs the second half of the loading motions.</p>	<p>iii. Inspect belts.</p>	<p>i. Misfire.</p> <p>ii. (a) Broken or damaged firing pin. (b) Broken lock spring.</p> <p>iii. Empty pocket in the belt.</p>

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SPECIAL STOPPAGES

Position of crank handle	Method of preparation	Immediate action	Prevention of recurrence	Probable cause
 <p>Indication.—Crank handle resting on roller.</p>	<p>Perform half the loading motions. Remove the fuze spring box and spring. Pull the crank handle on to the roller. Pull the belt to the left. Replace the fuze spring box with the spring detached from the fuze.</p>	<p>Remove the fuze spring box. Pull the belt to the left and return crank handle to the check lever. Replace the broken fuze or spring. If the spring is broken, adjust to the correct weight.</p>		<p>Broken fuze or fuze spring.</p>
 <p>Indication.—The extractor is unable to rise to its highest position.</p>	<p>Place two thick-rimmed dummy cartridges as the second and third rounds in the belt. Proceed to load, easing the crank handle forward the second time. When resistance is met, give the crank handle a light tap downwards.</p>	<p>If after applying the immediate action for a thick rimmed cartridge the stoppage recurs on reloading, repeat the immediate action and change the lock.</p>		<p>(a) Damaged cartridge grooves. (b) Broken gib spring. (c) Broken gib. 44</p>
	<p>(a) (b) (c) Unload and release the lock spring. Pull the belt until the first round is in the front of the bottom pawls. The man must now apply the I.A. as for broken lock spring. When the man has completed this I.A., he should be told that the gun only fired two rounds and stopped again in the same position.</p>	<p>(a) (b) (c) Apply the immediate action for the fourth position stoppage. After the lock has been changed the gun fires two rounds and then stops in the same position. The feed block will be changed.</p>		<p>Broken (a) Upper lever. (b) Lower lever. (c) Top pawls or spring.</p>

(This should lead him to inspect the feed block where the breakage will be found).

<p>(d) Set up as for empty pocket in the belt. When the man has completed the correct I.A. for the above, he will be told that the gun fired only two rounds and stopped again in the same position.</p> <p>1. Give the order "Load." As soon as the crank handle touches the check lever for the second time, say "Gun firing."</p> <p>2. Order "Load" and "Fire" followed by "Stop." Directly No. 1 releases pressure from the thumbpiece, say "Gun still firing."</p>	<p>(d) Apply immediate action as for empty pocket in the belt. The gun will fire two rounds and stop in the same position. The feed block will then be changed.</p> <p>1. No. 1 will remove a round from the belt.</p> <p>2. When the gun stops firing, he will pull the crank handle on to the roller.</p> <p>3. No. 2 will remove the belt.</p> <p>4. No. 1 will release the crank handle. The lock can then be changed with safety.</p>	<p>(d) Bottom pawls or springs.</p> <p>(a) Broken or worn nose of trigger or bent of tumbler.</p> <p>(b) Broken short arm of lock spring above trigger axis pin.</p>
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Note.—Should a stoppage occur in any position when the gun cannot be stopped by releasing the thumb-piece, the I.A. will always be: Crank the handle on to the roller and remove the belt.

In the case of a second position stoppage, extreme care must be taken that the extractor is kept down while the round is being removed

SECTION 7.—REPAIRS.

LESSON 27.—REPAIRS

*Instructor's Notes**Stores.—*

Gun, tripod, spare parts case and box, parts of an old belt, sufficient flannelette and lutin.

The lateral adjustment of the foresight will not be taught to private soldiers.

If lutin is not available, any suitable substance, e.g., plasticine or putty, may be used for instructional purposes.

1. Fitting spare discs for the muzzle attachment. Unscrew the front cone, cut the edge of the disc, driving sufficient metal up to provide a hold for the pliers. Remove the disc and replace it with a new one.

In replacing it may be necessary to tap the disc on to the front cone.

2. Fitting auxiliary packing gland. In the event of the packing gland being damaged by bullets, etc., it can be replaced by the auxiliary packing gland as follows:—

Remove the outer casing muzzle attachment, muzzle cup and damaged packing gland, screw in the auxiliary packing gland, using the combination tool, and lighten the fuze spring by about 3 lb.

3. Lateral adjustment of the foresight. If the foresight has become damaged or displaced, re-adjustment will be necessary. This will only be carried out by an experienced N.C.O. armourer.

It will be carried out on the 30-yards range.

Target.—Any target with a thick vertical line as an aiming mark with a pencil line $\frac{5}{8}$ in. to the right of the middle of the thick line, the pencil line being invisible to the firer.

Settling bursts will first be fired.

Then a group of ten rounds will be fired by inserting a punch between the firing lever and the safety catch.

If the gun is sighted correctly, the mean point of impact will be on the thin pencil line, i.e., $\frac{5}{8}$ in. to the right of the point aimed at.

If there is any lateral error, the foresight will be tapped in the same direction as the error, using a No. 3 punch and hammer.

Another burst of ten rounds will be fired after each adjustment until the sighting is correct. Adjustments are very fine and great care must be exercised in tapping the foresight. When the foresight is very tight, the bracket should be supported to prevent it from jarring loose. It is important that the socket of the tripod should be perfectly upright. After each group is fired, the aim must be carefully checked to see that the tripod has not moved.

4. Perforation of the barrel casing.

In the event of the barrel casing being pierced by bullets, etc., repairs will be carried out locally as follows:—

A pad of lutin, preferably wrapped in a piece of flannelette or cloth to prevent it from being squeezed through the hole or holes, is pressed over the latter and covered with an oiled pad of flannelette; the whole is then bound round with flannelette. This, while not preventing leakage entirely, should do so sufficiently to enable the gun to be kept fit for action.

Note.—A patch, first aid, has now been introduced and will replace lutin.

5. Use of the tool for repairing belts.

Remove the damaged strips and eyelets. If a long strip requires fitting, first join the two faces of the strip as follows:—

Place the eyelet in the hole of the dished end, insert the punch of the tool into the unopened end of the eyelet (the open end should rest on the die and gently press the handles together), then put the punch in the other end of the eyelet and press the handles. Keep the strip horizontal, move the handles of the tool backwards and forwards in a circular direction, with the punch of the tool as the centre, so as to shape the head of the eyelet.

Put the strips into position on the belt, insert the eyelet and repeat the above operation.

Short strips are fitted in a similar manner, except that they do not require to be joined at one end before being placed on the belt.

Care must be taken to press the eyelets as far through the strips as possible before using the tool.

6. To repair a torn belt.

If badly torn, cut out the torn portion and sew or rivet together the cut ends and cover with the brass strips. The cutting of the belt should be done in such a manner as to ensure that the repair to the top portion of the webbing does not coincide with the repair to the bottom portion.

SECTION 8.—BLANK FIRING ATTACHMENT

LESSON 28.—BLANK FIRING ATTACHMENT

*Instructor's Notes**Stores.—**Barrel, Mark II "D.P.B." (drill purposes, blank).**Cone, front, muzzle attachment, blank.**Cup, muzzle attachment blank.**Nut, adjusting, muzzle attachment, blank.**Screw, adjusting, muzzle attachment, blank.**Spanner, muzzle attachment, blank.*

1. The barrel is specially choked at the breech and is marked "D.P.B." on the trunnion block.

The adjusting screw is screwed into the front cone from the rear, so that its large end may engage in the muzzle cup.

The front cone with adjusting screw, assembles into the outer casing of the muzzle attachment in place of the existing front cone.

The adjusting nut screws on to the projecting end of the adjusting screw and locks against the face of the front cone.

The spanner is suitably arranged for the muzzle cup, adjusting screw and nut.

2. Adjustment of the gun when assembled with the special parts. The weight of the recoiling parts of the gun should not exceed 2 lb.

The weight of fuze spring should be about $4\frac{1}{2}$ lb.

The adjusting screw of the muzzle attachment should first be screwed inwards to the muzzle cup until it just begins to force the recoiling portions backwards; it should then be unscrewed $1\frac{3}{4}$ turns and secured in position by the nut. The screw may require further adjustment in order to obtain correct functioning, but in no case should the screw be less than 1 turn back from the muzzle cup. Adjustment should be made in quarter turns.

NOTES

1. Service guns only will be used for firing.

2. A belt, preferably part-worn as regards size of pockets, should be employed. The blank ammunition should be inserted crimped end flush with the front edge of the belt, in

groups of 10 rounds each. This number is sufficient for the purposes of locating machine gun fire and also ensures a longer life of choke in the barrel.

3. When firing becomes noticeably irregular, the barrel should be set aside for examination by an armourer.

4. The barrel casing will be filled with water as for ball ammunition.

5. When the gun is fitted with the blank firing attachment, it cannot be placed in its chest unless the outer casing of the muzzle attachment with its fittings is first removed.

6. On completion of blank firing the guns will immediately be restored to their normal condition for firing ball ammunition.

7. The gun will be cleaned in the normal way (i.e., as if the ball ammunition had been fired), except that no attempt will be made to clean the inside of the barrel in front of the choke.

SECTION 9.—INSTRUMENTS AND AIMING

GENERAL

1. All ranks must be proficient in the use of the following—

Aiming post.
Zero post.
Direction dial.
Elevating wheel.
Dial sight.
Aiming lamp.

2. Officers and N.C.Os. must be proficient in the use of the slide rule. The former and full rank N.C.Os. will also be trained to use:—

Director.
Plotter.

3. In addition to the above, all officers and N.C.Os. should be able to determine whether a dial sight is in adjustment. Similarly, those officers and N.C.Os. who are trained in the use of the director should be able to test the instrument for accuracy.

4. For the standard to be reached, see T.O.E.D.

LESSON 29.—TANGENT SIGHT AND FIXED SIGHT

Instructor's Note

Stores.—

Gun, tripod, belt box, aiming post, landscape target.

1. Setting the sights.

Explain and demonstrate:—

- i. The use of sights to obtain direction and elevation.
- ii. The method of adjusting the sights. Fifty yards will be taught as the smallest adjustment.
- iii. The correct line on the graduated plate for any particular range is the one under the figures indicating that range.
- iv. The fixed sight will be used up to 550 yards inclusive.

The men should be required to make several adjustments.

2. Rules of aiming.

Explain:—

- i. Sights must be upright. This is ensured by correct mounting of the tripod.
- ii. The eye should be as close to the aperture as possible.
- iii. The firer must look through and not at the aperture.

Demonstrate the common faults of aiming (see Pamphlet No. 3, Lesson 6).

Explain that, in aiming at a bullseye for instructional purposes, or at the aiming post or lamp, the aim must be taken at the lowest central portions, as the foresight will not show up clearly if laid on the centre.

3. Methods and sequence of instruction in laying an aim.

- i. Lay a correct aim at the aiming post *without* "holding." While laying, the chin must be supported on the hand. A belt box may be placed across the knees and the elbows rested on the box, or the box may be placed on the ground resting on end, and the arms rested on top.

Explain that direction is obtained by tapping the traversing handles, and elevation by turning the wheel.

- ii. Every man should view the aim, and in turn lay the gun, without holding.

Should any faults be detected, explain their effects, and ensure that such faults are remedied.

If a man's aim is incorrect, he must be convinced that it is so.

- iii. The men will be taught to lay on aim with "holding." The tripod must be in good condition; otherwise there will be considerable difference in aim with and without holding. There should be little difference.

- iv. Show how to lay an aim at points on a landscape target, and finally on natural objects.

- v. Show how to note a point of aim to the right or to the left of the original mark.

Tap the gun off and ask the men to describe where the gun is laid.

- vi. Demonstrate how to select and note a point of aim immediately above or below the target by moving the tangent slide up or down.

LESSON 30.—DIAL SIGHT (PLATE 3)

Instructor's Note

Stores.—

Gun, tripod, dial sight.

Explain and demonstrate the following:—

Collimator.

Lateral and vertical adjustment of collimator.

Dial and deflection drums.

Indicator bar.

Spare clinometer level.

Elevation drums.

Tapered bracket.

Description.—The sight consists of a tapered bracket with fixing screw, for attaching to the gun bracket.

Two elevation drums with quick release and pointers:—

(a) The range drum, graduated in 100s of yards up to 1,000 yards, and 50s of yards upwards.

(b) The angle of sight drum, graduated in 5s of minutes up to 10 degrees of elevation and depression.

A dial, marked in 10s of degrees from 0 to 180 degrees, left and right, with a quick release, also right and left deflection drums, marked in 10s of minutes.

An adjustable indicator bar, with arrows at each end for use with the deflection drums. This can be made to click or friction as desired by means of the milled head screw. Under this is housed a spare clinometer level.

On the left of the dial is a clinometer level. Mounted on top of the dial is a collimator with pyramid. This is adjustable vertically, by means of a slide with fine adjustment, and ramps. The whole of this portion is zeroed by means of a spring catch and horns, which can be freed by means of a quick release on the right. This allows the collimator to rotate. Between the horns is a fine adjustment worm which engages in the teeth of the bottom plate of the collimator.

LESSON 31.—AIMING WITH THE DIAL SIGHT

Stores:—

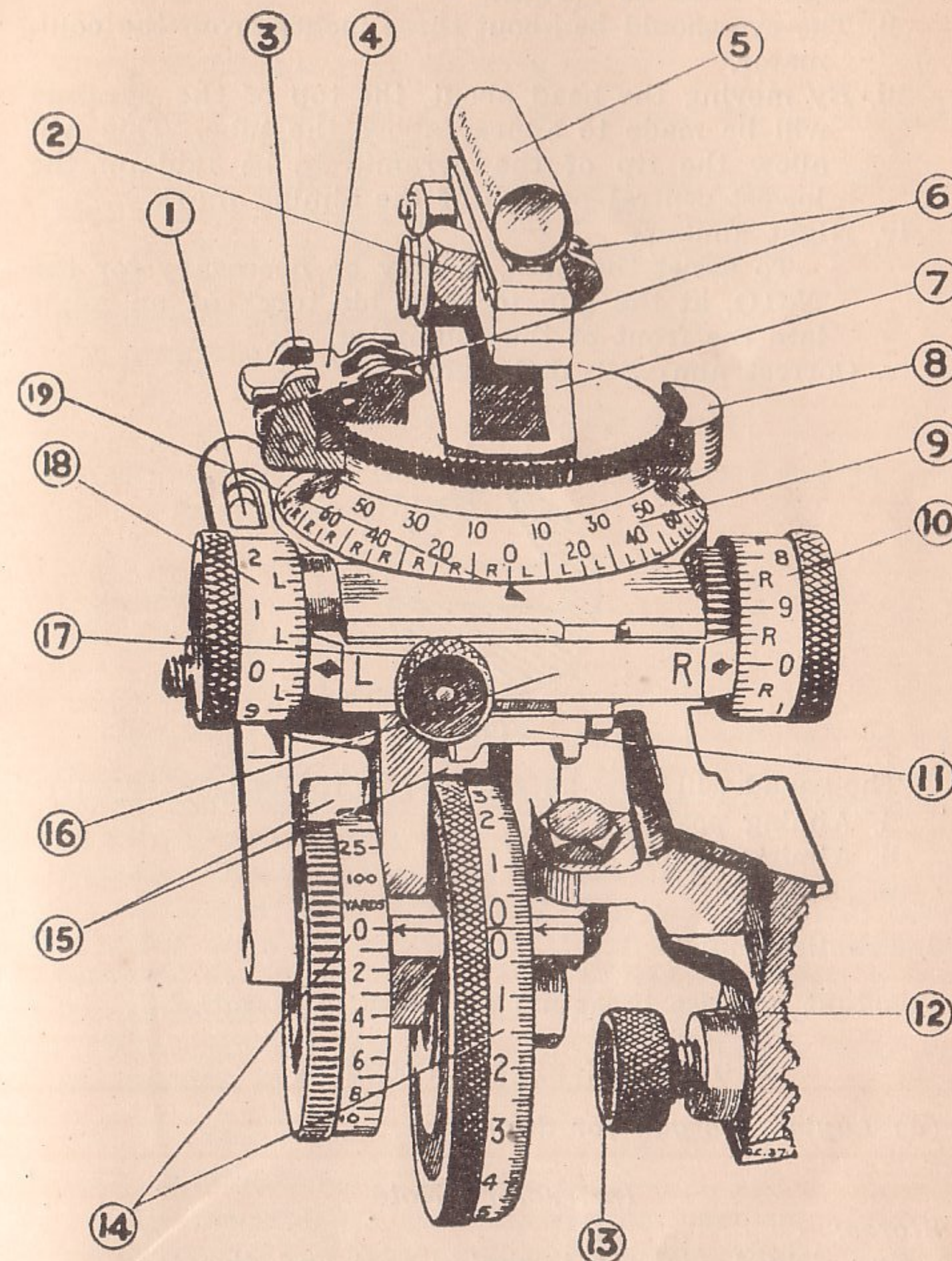
Instructor's Notes

As for Lesson 30, with addition of aiming post, aiming lamp and zero post.

A dark room or shed which can be illuminated quickly is an advantage, as faults in aiming can be shown by turning on the lights.

PLATE 3

DIAL SIGHT, M.G.



KEY

- | | |
|----------------------|---------------------------------|
| 1. Clinometer level. | 10. Deflection drum. |
| 2. Slide. | 11. For spare clinometer level. |
| 3. Horns. | 12. Tapered bracket. |
| 4. Spring catch. | 13. Fixing screw. |
| 5. Collimator. | 14. Elevation drums. |
| 6. Fine adjustment. | 15. Quick release. |
| 7. Ramps. | 16. Indicator bar. |
| 8. Quick release. | 17. Milled head screw. |
| 9. Dial. | 18. Deflection drum. |
| | 19. Pointer. |

1. Explain and demonstrate:—

- i. Sights must be upright.
- ii. The eye should be about three inches from the collimator.
- iii. By moving the head about, the top of the pyramid will be made to appear above the tube. This will allow the tip of the pyramid to be laid on the lowest central portion of the aiming mark.
- iv. Night aiming.

To assist the man, it may be necessary for the N.C.O. at the gun to shine his torch at an angle into the front of the collimator.

- v. Correct aim with dial sight.

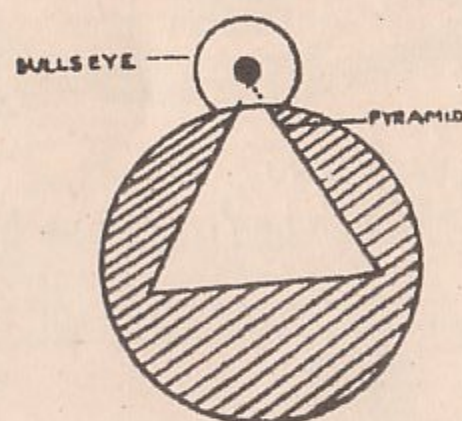


FIG. 1.

2. The squad will view an aim laid by the instructor on:—

- i. Aiming post.
- ii. Aiming lamp.
- iii. Zero post.

3. Practise squad.

Constant practise in actual darkness is essential.

LESSON 32.—DIRECTION

(a) Laying the gun for direction.

*Instructor's Note**Stores:—*

Gun, tripod, dial sight, aiming post and director.

1. Explain and demonstrate:—

Gun mounted, dial sight attached with all scales at zero.

A director will be mounted in a suitable position. On the order "Right (or left) . . . degrees . . . minutes," No. 1 will set the dial and deflection drums as ordered. He will tap the gun and elevate or depress the collimator until it is laid

on the centre of the director. The direction dial and deflection drums will be re-set at zero.

2. Practise squad.

(b) *Maintenance of direction.*

Note.—The aiming post will be put out in a suitable position by the instructor.

1. The collimator is rotated, and elevated or depressed until a correct aim is obtained on the aiming post.

2. In checking for direction during firing or on the command "Stop," the gun will be tapped until direction is obtained on the aiming post.

3. Practise squad.

LESSON 33.—ELEVATION

(a) *Placing elevation or depression on the gun by means of the dial sight.**Instructor's Note**Stores:—*

As for Lesson 32.

1. Explain and demonstrate:—

Gun mounted and dial sight attached with all scales at zero, aiming post put out and collimator adjusted to it. On a range and angle of sight being ordered, No. 1 places them on the elevation drums and levels the bubble by means of the elevating wheel. When levelling the bubble, No. 1 will retain his holding with his left hand. The collimator will then be adjusted to a correct aim on the aiming post. Orders in range to be given to the nearest 50 yards. Orders in elevation to be given to the nearest 5 minutes.

Note.—When a quadrant angle is ordered, the range drum will remain at zero.

2. Practise squad.

(b) *Maintenance of elevation.*

1. In checking for elevation during firing or on the command "Stop," the bubble will be brought central and the aim checked on the aiming post. Should the aim be incorrect for elevation, the setting of the elevation drums will be checked, and, if they are found to be correct, the collimator will be adjusted. When the setting of the elevation drums is found to be incorrect, it will be corrected, the bubble will be brought central and the collimator adjusted if necessary.

2. Practise squad.

LESSON 34.—RECORDING ON THE DIAL SIGHT THE QUADRANT ELEVATION OR QUADRANT ANGLE ON THE GUN

Instructor's Note

Stores:—

Gun, tripod, dial sight.

1. Explain and demonstrate:—

Gun mounted and laid on a target with any range on the tangent sight.

- i. No. 1 attaches the dial sight, places the same range on the range drum, levels the bubble by means of the angle of sight drum and then clamps up.

The two drums will now record the quadrant elevation.

- ii. No. 1 attaches the dial sight, sets the range drum at zero and levels the bubble by means of the angle of sight drum.

The resultant angle on the drum will be the quadrant angle.

2. Practise squad.

LESSON 35.—DIRECTION DIAL MK. II

Instructor's Note

Stores:—

Gun and tripod.

1. Explain and demonstrate:—

Graduations.

Markings "R" and "L."

Pointer.

Clamping screw.

- i. Description.

The direction dial is graduated from 0 to 180 degrees RIGHT and LEFT. 0 is marked by a screw. The scale can be rotated round the socket, and can be fixed in any position by a clamping screw. A pointer is fitted to the right hand side of the cross-head for use in connection with the dial.

- ii. To set the dial at zero.

No. 2 loosens the clamping screw, rotates the dial until 0 is opposite the pointer and then screws up the clamping screw.

- iii. To lay off an angle of direction by the dial.

Gun mounted and direction dial set at zero. No. 2 at the gun. No. 2 loosens the traversing clamp and swings the gun so that the pointer moves towards "R" or "L" as ordered. He adjusts the pointer to the number of degrees or minutes ordered and tightens up the traversing clamp.

Switches should be given out in multiples of 10 minutes, and adjustments made to within 10 minutes.

2. Practise squad.

LESSON 36.—ELEVATING WHEEL

Instructor's Note

Stores:—

Gun and tripod.

1. Explain:—

The elevating wheel is marked by wide notches for degrees, thin notches for ten minutes and dots for five minutes.

A pointer is attached to the elevating gear for use with the wheel.

The graduations on the wheel will be explained to the man.

2. Show how to elevate or depress the gun.

Gun mounted and laid on an aiming mark No. 1 at the gun. No. 1 will elevate or depress the gun the necessary amount by means of the wheel. On completion No. 1 will re-align his sights on the aiming mark.

3. Practise squad.

LESSON 37.—AIMING POST M.G., MARK III, AND ZERO POST M.G., MARK I

Instructor's Note

Stores:—

Gun, tripod, dial sight, aiming post and zero post.

1. Aiming post.—

- i. Explain and demonstrate:—

Folding arm.

Lamp bracket.

Securing extension.

- ii. Describe how the aiming post consists of a triangular base with three spikes for securing the post into the ground. The stand has an adjustable arm with an aiming mark and lamp bracket, and an extension to act as a support. The following will be explained to the man:—
- iii. A gun will be mounted, dial sight attached, and No. 3 will be instructed to put out the post about 15 yards to the left front of the gun. The aiming post should be vertical or lying on its side, with the flat side of the base and the securing extension on the ground.
- iv. Practise squad.

2. Zero post, M.G., Mark I.—

i. Explain:—

The post is 3 feet long; it has a ring 4 inches in diameter at the upper end, and the lower end is pointed.

ii. Show how to put out the zero post.

The gun will be mounted, the dial sight attached, and laid with any elevation. No. 1 at the gun. No. 3 a few yards in rear with the zero post.

The instructor will act as No. 1.

No. 3 will drive the zero post in about 10 yards in front.

No. 1 will direct No. 3 by signal to move the post for direction, and will adjust the collimator for elevation only, until his aim is on the point where the ring joins the stem.

iii. Practise squad.

LESSON 38.—LAMP, AIMING, M.G., MARK III

Instructor's Note

Stores:—

Aiming lamp and aiming post.

1. Explain and demonstrate:—

Aiming lamp.

The lamp is contained in a box divided into three partitions, one containing the lamp, another two batteries, and the third a two-way switch with wire lead to the external ring; line and reel, securing chain and spare bulb.

On the base of the box is a securing hook.

i. Attaching the lamp to the aiming post.

The box will be opened, the lamp removed and the cable passed through the slot in the side of the

box. The lamp will be secured to the extension above the aiming mark on the aiming post, with the bracket uppermost, by tightening the wing nut.

Note.—The box must be closed, and placed close to the aiming post with the ring facing No. 1 gun of each section.

ii. Attaching the line.

The reel will be removed from the box and the swivel hook will be clipped through the switch ring. To turn the light on or off, the line must be given a sharp pull.

iii. Securing the box.

In soft ground the hook will be released from its securing strap and stamped into the ground. On hard ground the securing chain will be used to anchor the box to a post or other suitable object.

2. Practise squad.

LESSON 39.—DIRECTOR, No. 4, MARK II (PLATES 4 AND 5)

Instructor's Note

Stores:—

Directors.

1. Explain and demonstrate:—

Focusing of telescope.

Pointer.

Degree scale on director.

Clinometer level and elevating gear.

Degree scale plate.

How to clamp the index plate and the functioning of the clamping screw.

Use of spirit level on stand.

Hook attached to base plate.

2. Describe how the instrument consists of:—

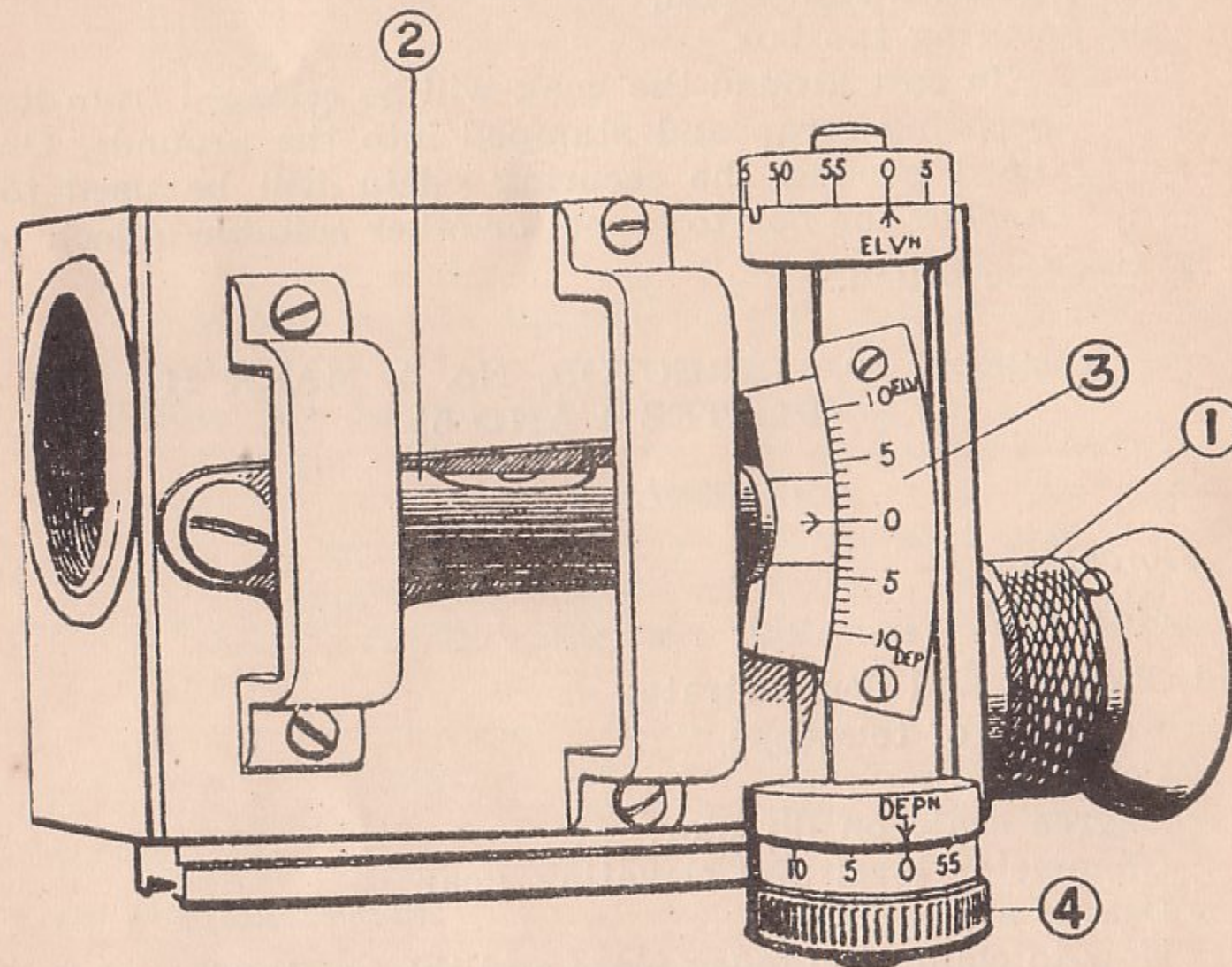
A telescope with vertical pointer contained in the box. The telescope can be focused by means of the eyepiece.

On the left of the box is a clinometer level, consisting of a bubble arm, degree scale, and micrometer heads marked in 5s of minutes. The top half of the degree scale and the top drum for elevation, the bottom half of the scale and the bottom drum for depression.

On the underside is a slider and spring for attaching to the director stand.

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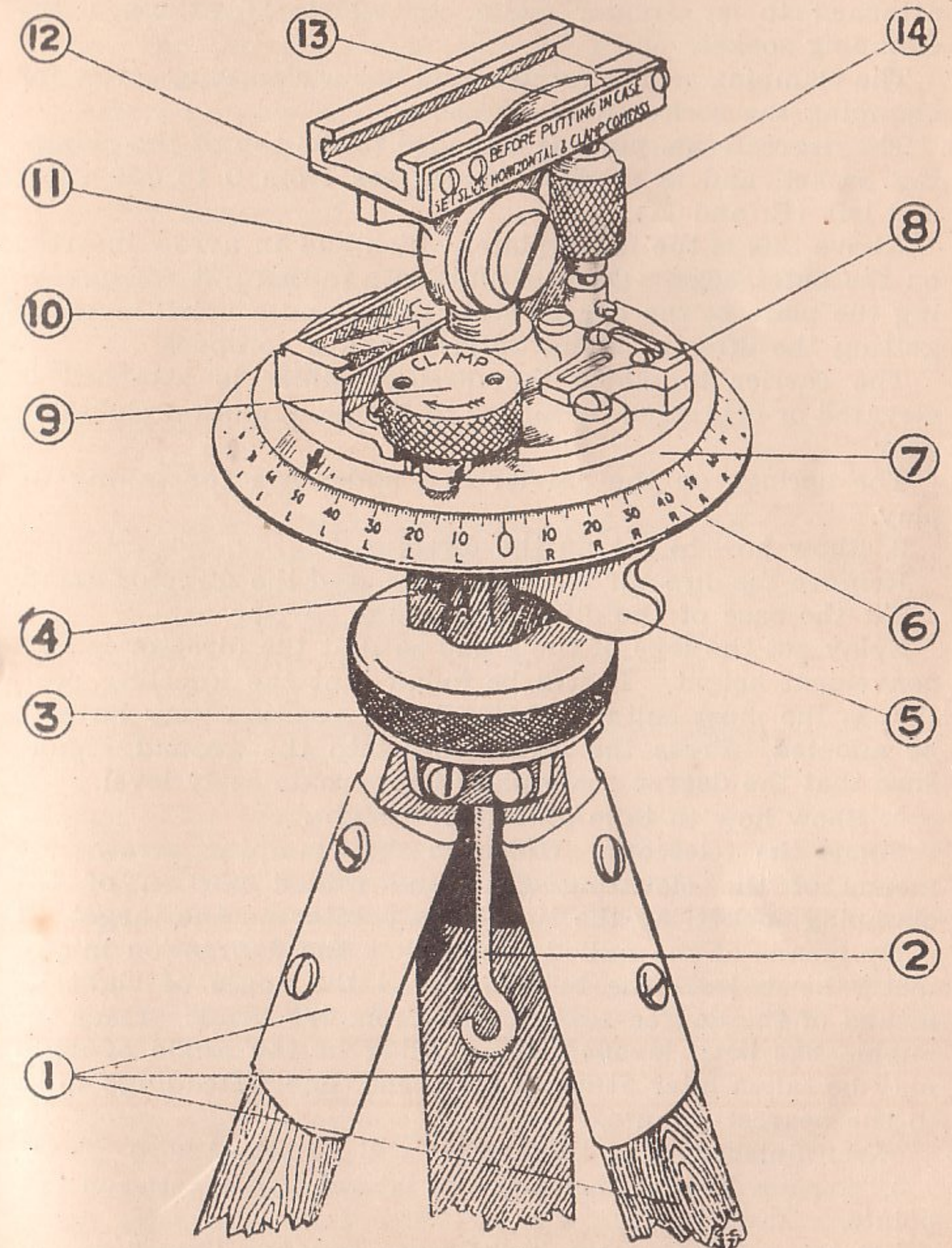
PLATE 4
DIRECTOR, No. 4, MARK II



KEY

- | | |
|----------------------------|---------------------------------|
| 1. For focusing telescope; | 3. Angle of sight degree scale. |
| 2. Clinometer level. | 4. For levelling bubble. |

PLATE 5
STAND DIRECTOR, No. 4, MARK II



KEY

- | | |
|------------------------|-----------------------|
| 1. Legs. | 8. Spirit level. |
| 2. Hook. | 9. Clamping nut. |
| 3. Base plate. | 10. Magnetic compass. |
| 4. Clamping socket. | 11. Carrier bracket. |
| 5. Clamping screw. | 12. Carrier. |
| 6. Degree scale plate. | 13. Side spring. |
| 7. Index plate. | 14. Elevating gear. |

The director stand consists of three hinged legs, between which is a hook for use with a plumb line. The legs are attached to a circular plate, to which is attached the clamping socket.

The clamping socket rotates, and has a clamping screw for clamping the socket to the base.

The degree scale plate is attached to the top of the clamping socket, and is marked in degrees from 0 to 180 right and left (R. and L.).

Above this is the index plate, which has an arrow inserted on the outer edge. On this plate is a milled nut for clamping the plate to the degree scale plate, and a spirit level for getting the director stand upright, and a compass.

The carrier to which the director slider is attached is elevated or depressed by means of the slow motion elevating gear.

The springs on the carrier and slider are for taking up play.

3. Show how to set up the director.

Remove the director from the case, and the director stand.

Fit the base of the director into the carrier.

Splay out the legs of the stand so that the director is at a convenient height. It will be found that the kneeling position is the most suitable, but a lower position may have to be adopted. Press the legs firmly into the ground. Make sure that the degree scale plate is approximately level.

4. Show how to take an angle of sight.

Focus the telescope. Unloosen the clamping screw. By means of the elevating gear and milled portion of the clamping socket lay the tip of the pointer on the target.

By means of the milled head below the depression micrometer head, level the bubble. Read the angle of sight by means of the degree scale and micrometer heads. Once the bubble has been levelled, the reading of the angle of sight may be taken later at any convenient time. Readings to be to the nearest minute.

When finished with, the arrows will be set at zero.

5. Explain how to measure the lateral angle between two points.

Set the pointer on the index plate opposite "zero" on the degree scale.

Tighten up the clamping nut. By means of the elevating gear and milled portion of the clamping socket, lay the pointer on the first point. Tighten up the clamping screw.

Loosen the clamping nut and lay the pointer on the second point.

Read off the number of degrees and minutes, direction right or left, from the degree scale to the nearest 10 minutes. Ensure that the degree scale plate does not slip when the index plate is moved. Always move the index plate by holding the carrier bracket, and not the director.

Before putting the director stand in its case, set the slide horizontal, clamp the compass and set the pointer on the index plate at 180 degrees.

6. Practise squad.

LESSON 39A.—DIRECTOR No. 9 (PROVISIONAL)

Instructor's Note

Stores.—Directors.

1. Explain and demonstrate:—

Body.

Telescope.

Angle of sight graticules and hair line.

Clinometer level and levelling screw.

Director level.

Dial and degree scale.

Deflection drums and quick release.

Clamping nut.

Fine adjustment screw and centralizing pointers.

2. Describe how instrument consists of a body and a telescope. The telescope has graticules marked in 10 minutes, measuring up to 5 degrees above and below the centre, and a central vertical hair line. There is no focussing.

(In a later pattern the angle of sight graticules measure up to 4 degrees only.)

On top of the telescope is the clinometer level, which is a fixture with the telescope, and the clinometer levelling screw. The action of the latter is to bring the bubble central by bringing the telescope level.

Below the clinometer levelling screw and on top of the body is the director level, by which it can be ensured that the director is upright. At the bottom of the body is the dial which measures 0-180 degrees right and left, and which is normally set at 180 degrees.

In front of the body are the deflection drums, which enable the director to be turned about the dial. The angle of deflection is measured to 5 degrees on the dial, and in degrees and minutes by the appropriate deflection drum.

Each deflection drum and dial has its own pointer. Between the deflection drums is a quick release, which, by

being depressed, enables the director to be turned about the dial, without the use of the deflection drums.

Below the body is a socket, by which the director is attached to a pivot on the stand. When attached, the director complete can be turned about the pivot, or clamped in the required direction by means of the clamping nut. Fine adjustments in direction can be made with the fine adjustment screw, below the left deflection drum. The two pointers alongside indicate when this is central.

3. Describe how stand consists of three legs of adjustable length. Adjustment is controlled by milled headed screws.

The legs are connected to a base plate by butterfly nuts.

In the centre of the base plate is a pivot connected to the former by a universal joint, and controlled by a universal joint clamping screw.

The pivot is protected by a metal screw cover.

4. Show how to set up director.

Undo the strap holding the legs together. By loosening the milled-headed screws extend the legs as necessary and tighten up the screws. Splay out the legs and mount the stand, with pivot at convenient height and approximately upright. If necessary, tighten butterfly nuts.

Press the legs firmly into the ground.

Remove pivot protector and attach director. Ensure that fine adjustment screw is central.

Loosen the universal joint clamping screw and centralise director level bubble. Tighten universal joint clamping screw.

5. To show how to take an angle of sight (normal).

Lay at target through telescope, if necessary by elevating or depressing telescope with clinometer level screw.

Tighten clamping nut.

Level clinometer bubble, look through telescope and read angle of sight from the graticules. For accuracy this may entail bringing the graticules on to the target by means of the fine adjustment screw.

Readings to be within 2 minutes.

Check that clinometer level bubble is still central.

6. To show how to take an angle of sight of more than 5 degrees.

If angle of sight is more than 5 degrees plus, lay director at a convenient point immediately below the target and note the angle of sight. By using the graticules measure the

vertical angle between this point and the target, and add the two angles together.

In the case of an angle of sight below 5 degrees minus take a convenient point above the target and proceed as before.

7. Explain how to measure the lateral angle between two points.

Set dial and deflection drums at zero.

Loosen clamping nut and lay director approximately at the first point. Tighten clamping nut, and bring hair line on to first point by means of the fine adjustment screw.

Using deflection drums, and if necessary the quick release, bring hair line on to second point.

Read degrees off dial and degrees and minutes off the appropriate deflection drum. Readings to be to the nearest minute.

Before putting director in its case centralise fine adjustment screw, and put dial pointed at 180 degrees and deflection drums at zero.

8. Practise squad.

LESSON 40.—SLIDE RULE, M.G., MARK III

Instructor's Note

Stores:—

Slide rules.

1. Description.

On the front side are extracts from the Range Tables.

On the sides are measuring scales.

Attached to the rule is a cord, 24 inches long.

On the back of the rule is the following:—

i. Safety angle scale.

On the right centre of the rule is marked a range to target scale, and on the right slide a range to troops scale, up to 500 yards in red and over 500 yards in black.

ii. Degree scale.

On the right side of the right slide is a degree scale and on top of the rule is an arrow.

To use:—To measure angular widths—when the rule is held at the length of the cord from the eye, the amount of slide projecting at the top of the rule will cover on the ground the amount in degrees and minutes shown opposite the arrow.

iii. Wind scale.

On the reverse of the right slide are the minute allowances. On the right of the rule is the range scale. On each side of the slide on the rule are marked the wind directions.

This scale is marked for a 20 m.p.h. wind.

To use:—Place the arrow on the slide opposite the range to target. Opposite the appropriate wind direction lines read the range and/or line corrections in minutes.

iv. V.I. scale.

On the left slide is marked the H.E. scale and an arrow. On the rule is marked the V.I. scale and a degree scale.

To use:—With a known V.I. and H.E. the angle subtended can be found by setting the H.E. on the sliding scale opposite the V.I. on the fixed scale. The angle can be read opposite the arrow on the right side of the slide. The V.I. or H.E. can be found in a similar manner when the remaining factors are known.

v. Displacement scale.

On the reverse of the left slide is the conversion scale marked in degrees, and on the left centre of the rule is a degree scale.

To use:—Place the angle T.O.G. opposite the oblique base (on the V.I. scale) and read the true base from the 90 degree index.

The range correction can also be obtained by adding 90 degrees to the angle T.O.G. when O is behind the gun position, or subtracting 90 degree from the angle T.O.G. when O is in front of the gun position.

Place this angle opposite the oblique base on the V.I. scale; the resultant reading from the 90 degrees index will be the range correction (see Lesson 109).

Reverse the slide—place the range to target (H.E. scale on slide) against the true base (V.I. scale) and read off the angle by the arrow on the right. This is the angle by which the director setting differs from 180 degrees. The angle at which the director must be set is also shown against the arrow.

2. Practise squad.

LESSON 40A.—THE SLIDE RULE

A new slide rule, designed for use with streamline ammunition, is in the course of production. The differences between this and the Mark III slide rule described in Lesson 40 are as follows:—

1. It is longer, to cater for the increased range.
2. The wind allowances are based on a 10 m.p.h. wind, and on the clock ray method of describing the wind which is to be found in the streamline range tables.
3. On the left column of the rule, near the bottom, is an arrow marked "Metres to Yards."

To convert metres to yards:—

Slide the left hand slide up until the figure 100 on the H.E. scale is opposite this arrow. Follow the H.E. scale up to the required number of metres. Read the figure opposite this on the V.I. scale. Multiply the figure on the V.I. scale by 10 to find the number of yards.

Example. How many yards is 2,500 metres?

Set the left slide as above.

Opposite 2,500 on the H.E. scale, you find 273 on the V.I. scale.

Multiply by 10.

Answer—2,730 yards.

4. Some of the columns on the front side of the slide rule have been omitted, so that the blank space may be used as a writing tablet.

LESSON 41.—FIELD PLOTTER

Instructor's Note

Stores:—

Field plotters.

1. Explain and demonstrate.
 - Scales on base.
 - Range arms.
 - Protractors.
 - Use of clamping screws.

i. Description.

The field plotter consists of a base of two slides, marked on the inner side in yards.

On each slide is a semi-circular protractor marked in degrees, from which run the range arms marked in yards, and tangent elevations.

For use with each scale is a clamp and a pointer. The following will be explained:—

ii. To use the field plotter.

The field plotter is used to solve triangles.

From it, given two sides and the included angle, the other angles and the third side can be found.

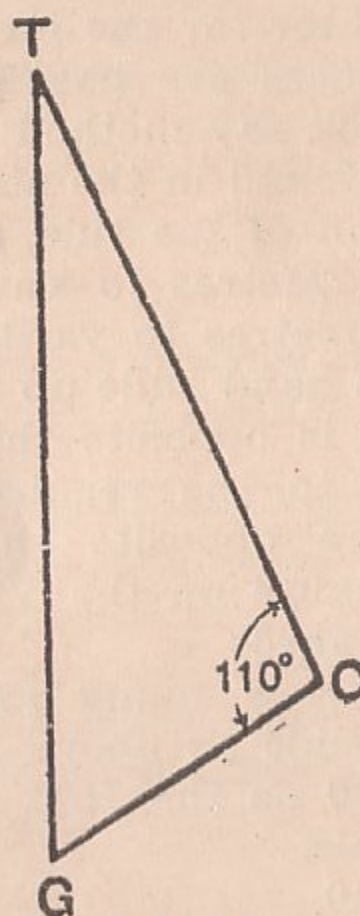


FIG. 2.

In the triangle TOG, Fig. 2, suppose OG to be the base (600 yards) and suppose TO to be the range (1,600 yards) and the angle TOG to be 110 degrees.

To find the angle TGO and TG:—

Loosen all clamps and draw out the slides on the base until the arrow on the right of the protractor can be set at 600 yards.

Clamp up the clamping screw on the base.

Move the arrows on the slide of the range arm to 1,600 yards and clamp up the screw. Move the range arm until 110 degrees on the protractor is opposite the arrow on the centre of the base plate. Clamp up the screw.

Reverse the plotter. Read the angle T.G.O. from the other protractor (52 degrees 40 minutes) and TG from the range arm (1,895 yards).

2. Practise squad.

SECTION 10.—INSTRUMENT TESTS

LESSON 42.—TESTING AND ADJUSTING THE DIAL SIGHT

Instructor's Note

Stores:—

Gun, tripod, dial sight, clinometer bar and level, plain target.

1. Explain and demonstrate:—

Elevation.

Mount the gun and attach the dial sight with all scales at zero.

Remove the outer casing, muzzle attachment, and insert the clinometer bar into the barrel. Place the clinometer level (known to be in adjustment) on the bar, and level the bubble by means of the handwheel. If the dial sight bubble is not central, it is out of adjustment.

Note the amount of error by centralizing the dial sight bubble by means of the angle of sight drum.

Note.—An armourer only will make the necessary adjustment.

2. Practise squad in above test.

3. Explain and demonstrate:—

Direction.

The collimator sight will be zeroed for line at the same time as the lateral adjustment of the foresight on the 30 yards range.

This is carried out in the following way:—

A thick line is drawn, parallel to, and 3.4 inches to the left of, the thin line on which the shots fall. If, when the M.P.I. of the group fired falls on the thin line, the tip of the pyramid coincides with the thick line, the collimator is in adjustment.

As an alternative test without firing, the gun will be laid on a distant target by means of the tangent sight, and, if the collimator, with all the scales set at zero is also laid for line on this target, it is in adjustment.

4. Practise squad.

5. Explain, without demonstration.

To adjust.

If the collimator requires adjusting, it is carried out in the following manner:—

Loosen the screws below and to the sides of the ramps. Tighten the appropriate screw until the line of sight is 3.4 inches to the left of the barrel and lock in position by tightening the other screw.

Note.—This adjustment should be carried out by an armourer only, but may in emergency be carried out by an experienced N.C.O.

LESSON 43.—TESTING THE DIRECTOR FOR ANGLE OF SIGHT

Instructor's Note

Stores:—

Gun, tripod, dial sight, director.

1. Mount a gun and attach a dial sight which is known to be in adjustment, and lay with the tangent sight at zero (0) on a distant object. With the range drum of the dial sight at zero, level the bubble by means of the angle of sight drum and note the reading.

Mount the director at the same height as the gun (*i.e.* the object glass to be on the same horizontal plane as the tangent sight). Place the angle read from the dial sight, on the director. Lay the director on the distant object, and, if the bubble is not then central, the director is not in adjustment. Note the amount of error by centralizing the director bubble by the micrometer head.

2. If a horizontal line is available, place the object glass at one end of the horizontal line (with the degree and minute scales at zero) and lay the pointer by means of the elevating gear, at the other end of the line.

The bubble should then be central; if it is not, turn the micrometer head until it is and note the error.

3. Practise squad.

Note.—Where an adjustment is necessary, it will be carried out by an armourer.

LESSON 43A.—TESTING THE No. 9 MK. 1 DIRECTOR FOR ANGLE OF SIGHT.

Instructor's Note

Stores.—Gun, tripod, dial sight, director.

1. Mount a gun, attach a dial sight known to be in adjustment, and lay with the tangent sight at zero (0) on a distant

object. With the range drum of the dial sight at zero, level the bubble by means of the angle of sight drum and note the reading.

Mount the director at the same height as the gun (*i.e.*, object glass on the same level as the tangent sight) and take angle of sight to distant object.

If this is the same as the reading on the angle of sight drum the director is in adjustment. If not, note the amount of error.

2. If a horizontal line is available (*see* para. 3 below), place the object glass at one end of the horizontal line and take the angle of sight to the other end. If this is zero the director is in adjustment, if not, note the error.

3. To lay out a horizontal plane, and test director for angle of sight.

1. Select a position where there are two walls or upright posts, about 200 yards apart, and as far as possible in the same horizontal plane.

ii. Take director to one wall (A), if possible a corner of a house. Lay director at the other wall (B), and direct an assistant to make a mark on (B), which appears to have no angle of sight (*i.e.*, an angle of sight of zero).

Make a mark on (A) level with the object glass.

iii. Take director to (B), mount it with object glass level with the mark, and lay it at mark on (A).

(a) If mark on (A) has no angle of sight, the two marks are on the same horizontal plane and the director is in adjustment.

(b) If the mark on (A) appears to show an angle of sight, make a second mark which has not.

(c) By measurement, make a third mark (X) on (A), midway between the two existing marks. (X) is on the same horizontal plane as the mark on (B).

iv. (a) Any director may now be tested for angle of sight and the errors, if any, noted.

(b) Adjustments will only be made by an armourer.

4. Practise squad.

Note.—Where an adjustment is necessary, it will be carried out by an armourer.

LESSON 44.—TESTING AND ADJUSTING THE CLINOMETER LEVEL

Instructor's Note

Stores:—

Gun, tripod, dial sight, clinometer bar and level.

1. Explain and demonstrate:—

- i. Gun mounted, dial sight attached, outer casing, muzzle attachment removed.
- ii. Place the clinometer level bar into the barrel and attach the level. Centralize the bubble by means of the hand-wheel. Centralize the dial sight bubble by means of the angle of sight drum.
- iii. Reverse the clinometer level and note the position of the bubble:—
 - (a) If central, the clinometer level is in adjustment.
 - (b) If displaced, this indicates that an error is present.

2. Practise squad.

3. Explain, without demonstration.

To adjust:—

- i. In the case of iii (b) leave the clinometer level on the bar, and level the bubble by means of the hand-wheel. Level the dial sight bubble by means of the angle of sight drum and note the variation from its former reading.
- ii. Having noted the variation, halve it and set the pointer to this reading, then releve the dial sight bubble by means of the hand-wheel.
- iii. With a No. 3 punch, loosen the capstan-headed screws on the clinometer level and, by tightening the appropriate screw, level the bubble. Retighten the other screw, which then acts as a locking screw. Care must be taken that the dial sight bubble is not displaced during this adjustment.
- iv. Retest the clinometer level as in i, ii and iii, above.

Note.—This adjustment should be carried out by an armourer only, but may in emergency be carried out by an experienced N.C.O.



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